

	SURFACE VEHICLE STANDARD	SAE	J442 NOV2008
		Issued Revised	1952-01 2008-11
		Superseding	J442 MAY2006
Test Strip, Holder, and Gage for Shot Peening			

RATIONALE

Section 6.4 – The flatness of the zero block should be changed to ± 0.005 mm flatness from ± 0.001 mm flatness because this degree of precision is not warranted for the measurement ranges required (0-0.610 mm range).

Section 7.3 – Note added to indicate that all dimensions are in millimeters (mm) unless otherwise specified.

1. SCOPE

This SAE Standard defines requirements for equipment/supplies to be used in measuring shot peening intensity. Guidelines for the use of these articles (test strip, holding fixture, and gage) are also included.

2. REFERENCES

2.1 Related Publications

The following publications are provided for information purposes only and are not a required part of this specification. The latest issue of SAE publications shall apply.

2.1.1 SAE Publications

Available from SAE International, 400 Commonwealth Drive, Warrendale, PA 15096-0001, Tel: 877-606-7323 (inside USA and Canada) or 724-776-4970 (outside USA), www.sae.org.

SAE J443 Procedures for Using Standard Shot Peening Test Strip

SAE AMS-S-13165 Shot Peening of Metal Parts

2.1.2 ASTM Publication

Available from ASTM International, 100 Barr Harbor Drive, P.O. Box C700, West Conshohocken, PA 19428-2959, Tel: 610-832-9585, www.astm.org.

ASTM E 18 Standard Test Method for Rockwell Hardness and Rockwell Superficial Hardness of Metallic Materials

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3. OUTLINE OF METHOD OF CONTROL

The control of a peening machine operation is primarily a matter of the control of the properties of a stream of shot in relation to the work being peened. The basis of measurement of these properties is as follows:

If a flat piece of steel (the test strip) is clamped to a solid block (the test strip holder) and then exposed to a stream of shot, it will be curved upon removal from the block. The curvature is due to residual compressive stresses induced by the shot impacts, causing the peened face to be convex. The curvature serves as a means of measuring the effect of the shot stream. The degree of the curvature depends upon the properties of the shot stream, the properties and mounting of the test strip, and the exposure condition.

3.1 Properties

3.1.1 Shot Stream

The properties of the shot stream are: shot material (includes chemical and physical characteristics), size, shape, velocity, directional consistency, and shot flow rate.

3.1.2 Test Strip

The properties of the test strip are: material (includes chemical and physical properties), hardness, physical dimensions, and the extent of any internal stresses. The properties of the test strip mounting are flatness, rigidity, and the location and force of the holding means.

3.1.3 Exposure

The properties of exposure to the blast stream are length of time, angle of impact, and the degree of uniformity and consistency of the geometric relationship between the shot stream and test strip.

3.2 Standards

Based on these principles, the SAE has adopted the following standards: test strips, holding block, and gage. Specifications for these parts, the method of use, and a standard designation are presented herein.

4. SPECIFICATIONS OF INTENSITY MEASURING EQUIPMENT

4.1 Test Strips and Holding Fixture

Standard test strips, N, A, and C are shown in Figure 1 and test strip holder is shown in Figure 2. The approximate relationships between readings of test strips N, A, and C (for conditions of identical blast and exposure) are as follows:

$C \text{ strip reading} \times 3.5 = A \text{ strip reading}$

$A \text{ strip reading} \times 3.0 = N \text{ strip reading}$

4.2 Gage

The gage (Almen gage) for determining the curvature of the test strip must incorporate the elements shown in Figure 3. Curvature of the test strip is determined by a measurement of the height of the combined longitudinal and transverse arc across standard chords. This arc height is obtained by measuring the displacement of a central point on the nonpeened surface from the plane of four balls forming the corners of a particular rectangle. To use this gage, the test strip is located so that the indicator spindle bears against the center of the NONPEENED surface, one long edge of the strip bearing against the two back stops. The test strip is then centered by placing the ends even with the edges of the base, or by resting the ends against built-in end stop(s).

5. DESIGNATION STANDARD OF INTENSITY MEASUREMENT

5.1 Primary Standard

The standard designation of intensity measurement includes the gage reading and the test strip used. It may be explained by the example shown in Figure 4.

5.2 Transition Standard

Gages utilizing the inch-pound system (English units) may be encountered during the period of transition to SI. The designation of intensity measurement in this temporary alternate is explained in the example shown in Figure 5.

6. MAINTENANCE, CALIBRATION AND USE

6.1 Test Strips

After removal from the test strip holder, test strips should not be replaced, re-used, or shot peened for any additional time.

6.2 Holding Fixture

The test strip contact area of the holding fixture shall be checked for flatness on a periodic basis. Flatness of the test strip contact area shall not exceed 0.1 mm. In addition to a dimensional check for flatness, holding fixtures shall be checked visually for the following characteristics:

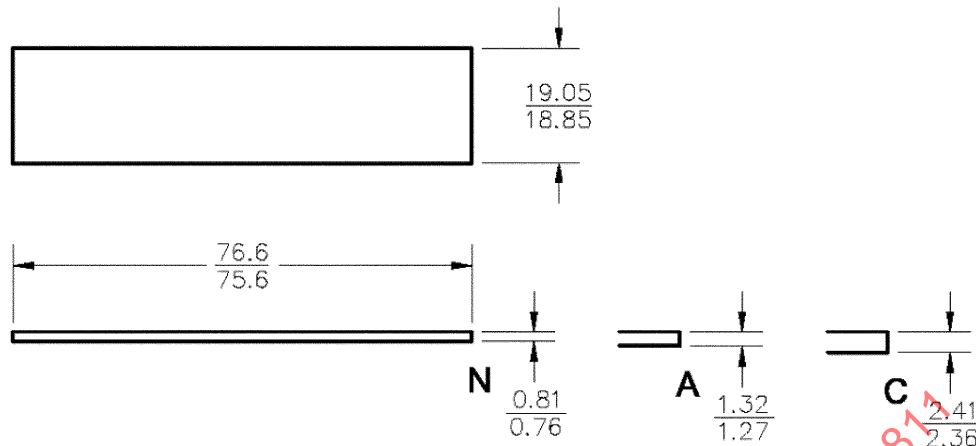
- a. Burrs or raised material that can be caused by damage or excessive peening (particularly on the holding fixture end faces).
- b. Particles of shot or beads that could become trapped under the test strip during installation.
- c. Damage to threads that may prevent one or more screws from adequately holding the test strip in place.

6.3 Gage

Locating balls and indicator tip shall be checked periodically for wear. Any visual signs of wear or flat spots on the ball greater than 1.0 mm (.039 inch) shall be cause for repair of the gage such that new round surfaces are in contact with the test strip. Posts should be inspected for grooves that may interfere with proper seating of the test strip on the 4-ball platform and, if necessary, replaced. The indicator shall be calibrated periodically over the range used for measuring test strips. The calibration tolerance for the indicator shall not exceed 0.005 mm. The use of calibration blocks, either flat, curved, or equipped with steps, is recommended.

6.4 Zero Block

A zero block, approximately the size of an Almen strip in length and width or large enough to contact the Almen gage 4-balls and indicator tip, with a minimum thickness of 5 mm shall be used to set the zero datum of the Almen gage. Flatness of the zero blocks shall be within ± 0.005 mm. Lapping the surface to achieve flatness is recommended.



Pre-bow: The arc height as measured by the Almen gage prior to peening. The maximum allowed pre-bow for each strip is as follows:

N - .025

A - .025

C - .038

Material: SAE 1070 cold rolled spring steel.

Edge Type: Number 1 (does not apply to ends of strip)

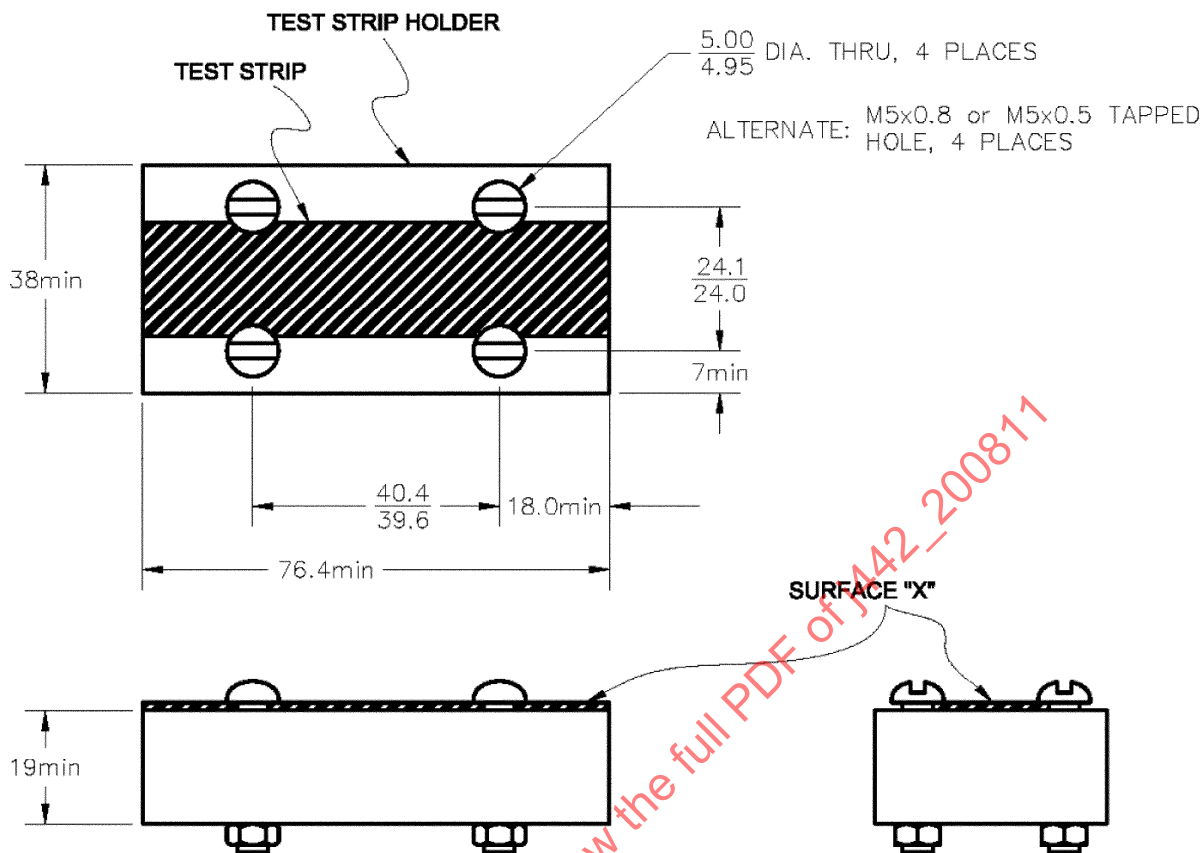
Finish: Plain tempered, all burrs removed.

Heat Treatment: All strips must be uniformly hardened and tempered to produce tempered martensite having a hardness, as measured on the surface, of HRC 44-50 (HRA 72.5-76.0 for the "N" strip).

Surface Carbon: Strips shall be free from alteration of surface carbon to the degree that any difference in average hardness between the surface and subsurface shall not exceed two points as measured on the Rockwell 30-N scale. The average of at least four readings in each region should be used to make the comparison. Any such determinations must be made on strips which have not been shot peened, and will preclude other use of strip to be tested. Surface hardness readings that are less than subsurface readings indicate evidence of decarburization. Surface readings which are higher than corresponding subsurface values indicate carburization.

Example: If the average surface hardness is 62.5 on the Rockwell 30-N scale and, after careful grinding, a region below the surface is found to be 64.0 on the Rockwell 30-N scale - the strip is acceptable. If the subsurface reading had been 65.0 on the Rockwell 30-N scale, the difference (2.5 points) being over two points constitutes grounds for rejection.

FIGURE 1 - TEST STRIP SPECIFICATIONS



Recommended Material for test Strip Holder - Any alloy or carbon steel, hardened to 57 HRC for a minimum depth of 0.7mm. Alternate materials and thicknesses may be used when their wear and deformation characteristics do not adversely affect the performance of the test strip.

One or two additional holes may be added to facilitate mounting the holder to a fixture. The hole(s) may be threaded and shall not extend into the strip contact surface of the holder.

Use M5 socket head or pan head screws and hex or square nuts.

Alternate: Use screws only in tapped holes.

FIGURE 2 - ASSEMBLED TEST STRIP AND HOLDER