

DUAL SIDED SHOT PEENING OF BLISK AIRFOILS

ABSTRACT

5 Dual sided shot peening system includes pressurized air
supply in communication with independently controllable first
and second air pressure regulators in communication with
first and second shot supplies and independently controlled
first and second shot flow control valves disposed between
first and second nozzles and the shot supplies. Computer may
10 be in control of regulators and valves. Nozzle supports may
fixedly or movably support nozzles during shot peening. The
system may be used for simultaneously shot peening first and
second sides of a portion of a workpiece such as airfoils of
a BLISK. First and second streams from first and second
15 nozzles may have different properties and may be varied
during shot peening.

[Figure 1]