

**Teraspindade ettevalmistamine enne
värvide ja nendega seotud materjalide
pealekandmist. Metalliliste
jugapuhastusabrasiivide tehnilised andmed.
Osa 1: Üldtutvustus ja liigitus**

Preparation of steel substrates before application of
paints and related products - Specifications for
metallic blast-cleaning abrasives - Part 1: General
introduction and classification

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN ISO 11124-1:1999 sisaldab Euroopa standardi EN ISO 11124-1:1997 ingliskeelset teksti.</p> <p>Käesolev dokument on jõustatud 12.12.1999 ja selle kohta on avaldatud teade Eesti standardiorganisatsiooni ametlikus väljaandes.</p> <p>Standard on kättesaadav Eesti standardiorganisatsioonist.</p>	<p>This Estonian standard EVS-EN ISO 11124-1:1999 consists of the English text of the European standard EN ISO 11124-1:1997.</p> <p>This document is endorsed on 12.12.1999 with the notification being published in the official publication of the Estonian national standardisation organisation.</p> <p>The standard is available from Estonian standardisation organisation.</p>
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<p>Käsitlusala:</p> <p>EN ISO 11124-1 see osa kirjeldab selliste metalliliste jugapuhastusabrasiivide liigitust, mida kasutatakse teraspindade puhastamiseks enne värvide ja nendega seotud materjalidega katmist. Standardi see osa määrab kindlaks näitajad, mida vajatakse seesuguste abrasiivide täielikuks tähistamiseks. Standardi see osa kehtib ainult tarnitavate abrasiivide kohta, mis on veel uued ja kasutamata. Standardi seda osa ei kohaldata abrasiividele nende kasutamise ajal ega pärast kasutamist.</p>	<p>Scope:</p>
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ICS 25.220.10, 87.020

Võtmesõnad: abrasiivid, aluspinnad, jugapuhastus, lakid, liigitus, metallabrasiivid, osakese suurus, tehnilised andmed, terastooted, tähistamine, värvid

ICS 87.020

Descriptors: Abrasives, blast-cleaning, classification.

English version

Preparation of steel substrates before application of paints and related products
Specifications for metallic blast-cleaning abrasives

Part 1: General introduction and classification
(ISO 11124-1:1993)

Préparation des subjectiles d'acier avant
appliacion de peintures et de produits
assimilés – Spécifications pour abrasifs
métalliques destinés à la préparation par
projection – Partie 1: Introduction
générale et classification
(ISO 11124-1:1993)

Vorbereitung von Stahloberflächen vor
dem Auftragen von Beschichtungsstoffen –
Anforderungen an metallische
Strahlmittel – Teil 1: Allgemeine
Einleitung und Einteilung
(ISO 11124-1:1993)

This European Standard was approved by CEN on 1996-12-27.

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Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

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Foreword

International Standard

ISO 11124-1:1993 Preparation of steel substrates before application of paints and related products – Specifications for metallic blast-cleaning abrasives – Part 1: General introduction and classification,

which was prepared by ISO/TC 35 'Paints and varnishes' of the International Organization for Standardization, has been adopted by Technical Committee CEN/TC 139 'Paints and varnishes', the Secretariat of which is held by DIN, as a European Standard.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, and conflicting national standards withdrawn, by July 1997 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard:

Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland, and the United Kingdom.

Endorsement notice

The text of the International Standard ISO 11124-1:1993 was approved by CEN as a European Standard without any modification.

Introduction

This is one of a number of parts of ISO 11124 specifying requirements for metallic abrasives for blast-cleaning.

Test methods for metallic blast-cleaning abrasives are given in the various parts of ISO 11125 (see annex A).

The requirements for non-metallic abrasives commonly used for blast-cleaning are specified in the various parts of ISO 11126. Test methods to be used to define these requirements are contained in the various parts of ISO 11127 (see annex A).

Abrasive blast-cleaning techniques are widely used to clean and prepare surfaces. During work on development of a series of International Standards dealing with the preparation of steel substrates before application of paints and related products, it was decided that a need existed for a series of International Standards covering those blast-cleaning abrasives commonly used in preparation of steelwork.

The type of blast-cleaning abrasive used and its particle shape can significantly affect the surface appearance and profile form of the treated surface.

The informative supplement to ISO 8501-1¹⁾ provides photographic examples of the change in appearance imparted to steel when blast-cleaned with different abrasive types.

ISO 8503-2²⁾ describes the assessment of the surface roughness of prepared surfaces using comparators. Table 1 of this part of ISO 11124 identifies the type of comparator to be used with each of the blast-cleaning abrasives considered.

1) ISO 8501-1:1988/Suppl, *Preparation of steel substrates before application of paints and related products — Visual assessment of surface cleanliness — Part 1: Rust grades and preparation grades of uncoated steel substrates and of steel substrates after overall removal of previous coatings — Informative Supplement to part 1: Representative photographic examples of the change of appearance imparted to steel when blast-cleaned with different abrasives.* (To be published.)

2) ISO 8503-2:1988, *Preparation of steel substrates before application of paints and related products — Surface roughness characteristics of blast-cleaned steel substrates — Part 2: Method for the grading of surface profile of abrasive blast-cleaned steel — Comparator procedure.*

WARNING — Equipment, materials and abrasives used for surface preparation can be hazardous if used carelessly. Many national regulations exist for those materials and abrasives that are considered to be hazardous during or after use (waste management), such as free silica or carcinogenic or toxic substances. These regulations are therefore to be observed. It is important to ensure that adequate instructions are given and that all required precautions are exercised.

1 Scope

This part of ISO 11124 describes a classification of metallic blast-cleaning abrasives for the preparation of steel substrates before application of paints and related products.

It specifies the characteristics which are required for the complete designation of such abrasives.

This part of ISO 11124 applies to abrasives supplied in the "new" or unused condition only. It does not apply to abrasives either during or after use.

NOTE 1 Although this part of ISO 11124 has been developed specifically to meet requirements for preparation of steelwork, the properties specified will generally be appropriate for use when preparing other material surfaces, or components, using blast-cleaning techniques. These techniques are described in ISO 8504-2:1992, *Preparation of steel substrates before application of paints and related products — Surface preparation methods — Part 2: Abrasive blast-cleaning*.

2 Definitions

For the purposes of this part of ISO 11124, the following definitions apply.

2.1 blast-cleaning abrasive: Solid material intended to be used for abrasive blast-cleaning.

2.2 abrasive blast-cleaning: Impingement of a high-kinetic-energy stream of blast-cleaning abrasive on to the surface to be prepared.

2.3 shot: Particles that are predominantly round, that have a length of less than twice the maximum particle width and that do not have edges, broken faces or other sharp surface defects.

2.4 grit: Particles that are predominantly angular, that have fractured faces and sharp edges and that are less than half-round in shape.

2.5 cylindrical: Sharp-edged particles, having a diameter to length ratio of 1:1, cut so that their faces are approximately at right angles to their centreline.