

Preparation of steel substrates before application of
paints and related products - Specifications for
non-metallic blast-cleaning abrasives - Part 7: Fused
aluminium oxide (ISO 11126-7:2018)

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

See Eesti standard EVS-EN ISO 11126-7:2018 sisaldab Euroopa standardi EN ISO 11126-7:2018 ingliskeelset teksti.	This Estonian standard EVS-EN ISO 11126-7:2018 consists of the English text of the European standard EN ISO 11126-7:2018.
Standard on jõustunud sellekohase teate avaldamisega EVS Teatajas	This standard has been endorsed with a notification published in the official bulletin of the Estonian Centre for Standardisation.
Euroopa standardimisorganisatsioonid on teinud Euroopa standardi rahvuslikele liikmetele kättesaadavaks 03.10.2018.	Date of Availability of the European standard is 03.10.2018.
Standard on kättesaadav Eesti Standardikeskusest.	The standard is available from the Estonian Centre for Standardisation.

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English Version

Preparation of steel substrates before application of paints
and related products - Specifications for non-metallic
blast-cleaning abrasives - Part 7: Fused aluminium oxide
(ISO 11126-7:2018)

Préparation des subjectiles d'acier avant application de
peintures et de produits assimilés - Spécifications pour
abrasifs non métalliques destinés à la préparation par
projection - Partie 7: Oxyde d'aluminium fondu (ISO
11126-7:2018)

Vorbereitung von Stahloberflächen vor dem Auftragen
von Beschichtungsstoffen - Anforderungen an
nichtmetallische Strahlmittel - Teil 7: Elektrokorund
(ISO 11126-7:2018)

This European Standard was approved by CEN on 12 August 2018.

CEN members are bound to comply with the CEN/CENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the CEN-CENELEC Management Centre or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the CEN-CENELEC Management Centre has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION
COMITÉ EUROPÉEN DE NORMALISATION
EUROPÄISCHES KOMITEE FÜR NORMUNG

CEN-CENELEC Management Centre: Rue de la Science 23, B-1040 Brussels

European foreword

This document (EN ISO 11126-7:2018) has been prepared by Technical Committee ISO/TC 35 "Paints and varnishes" in collaboration with Technical Committee CEN/TC 139 "Paints and varnishes" the secretariat of which is held by DIN.

This European Standard shall be given the status of a national standard, either by publication of an identical text or by endorsement, at the latest by April 2019, and conflicting national standards shall be withdrawn at the latest by April 2019.

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. CEN shall not be held responsible for identifying any or all such patent rights.

This document supersedes EN ISO 11126-7:1999.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Bulgaria, Croatia, Cyprus, Czech Republic, Denmark, Estonia, Finland, Former Yugoslav Republic of Macedonia, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Romania, Serbia, Slovakia, Slovenia, Spain, Sweden, Switzerland, Turkey and the United Kingdom.

Endorsement notice

The text of ISO 11126-7:2018 has been approved by CEN as EN ISO 11126-7:2018 without any modification.

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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 documents 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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For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: www.iso.org/iso/foreword.html.

This document was prepared by Technical Committee ISO/TC 35 *Paints and varnishes*, Subcommittee SC 12 *Preparation of steel substrates before application of paints and related products*.

This second edition cancels and replaces the first edition (ISO 11126-7:1995), which has been technically revised. It also incorporates Technical Corrigendum ISO 11126-7:1995/Cor 1:1999.

The main changes compared to the previous edition are as follows:

- [Tables 1](#) and [2](#) and [Annex A](#) have been technically revised.
- Annex B has been added.

A list of all parts in the ISO 11126 series can be found on the ISO website.

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

Part 7: Fused aluminium oxide

WARNING — Equipment, materials and abrasives used for surface preparation can be hazardous. It is important to ensure that adequate instructions are given and that all required precautions are exercised

1 Scope

This document specifies requirements for fused aluminium oxide abrasives, as supplied for blast-cleaning processes. It specifies ranges of particle sizes and values for apparent density, bulk density, Mohs hardness, moisture content, conductivity of aqueous extract and water-soluble chlorides.

The requirements specified in this document apply to abrasives supplied in the "new" condition only. They do not apply to abrasives either during or after use.

Test methods for non-metallic blast-cleaning abrasives are given in the various parts of ISO 11127.

NOTE 1 Information on commonly referenced national and international standards is given in Bibliography.

NOTE 2 Although this document 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.

2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 11127-1, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 1: Sampling*

ISO 11127-2, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 2: Determination of particle size distribution*

ISO 11127-3, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 3: Determination of apparent density*

ISO 11127-4, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 4: Assessment of hardness by a glass slide test*

ISO 11127-5, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 5: Determination of moisture*

ISO 11127-6, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 6: Determination of water-soluble contaminants by conductivity measurement*

ISO 11127-7, *Preparation of steel substrates before application of paints and related products — Test methods for non-metallic blast-cleaning abrasives — Part 7: Determination of water-soluble chlorides*

3 Terms and definitions

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <https://www.electropedia.org/>

3.1

fused aluminium oxide

synthetic mineral blast-cleaning abrasive, which is classified as two types, A and WA

Note 1 to entry: Type A: This type is mainly composed of crystalline corundum which is brown in colour and consists of a solid solution containing a minimum of 94 % aluminium oxide and a maximum of 4 % titanium dioxide.

Note 2 to entry: Type A is produced by fusing bauxite with the appropriate quantity of titanium dioxide and reducing agent in an electric furnace, cooling to form lumps and then crushing and sieving to size.

Note 3 to entry: Type WA: This type consists of crystalline corundum which is whitish in colour and contains at least 99 % aluminium oxide. It is produced by fusing pure grade Bayer alumina in an electric arc furnace followed by a slow solidification process.

4 Designation of abrasives

Fused aluminium oxide abrasives shall be identified by "Abrasive ISO 11126" and the abbreviation N/FA-A or N/FA-WA indicating non-metallic, fused aluminium oxide abrasive type A or WA. This shall be followed, without spaces, by an oblique stroke and then the symbol G to indicate the required particle shape of the abrasive, when purchased, as grit.

The designation shall be completed by numbers denoting the particle size range, in millimetres, required (see [Table 1](#)).

Table 1 — Particle size distribution

Particle size range ^a mm			0,045 to 0,180	0,125 to 0,300	0,212 to 0,500	0,300 to 0,710	0,355 to 0,850	0,500 to 1,18	0,850 to 2,00	1,18 to 2,80
Oversize	Sieve size	mm	0,180	0,300	0,500	0,710	0,850	1,18	2,00	2,80
	Residue % (mass fraction)	max.	0	0	0	0	0	0	0	0
Nominal size	Sieve size	mm	0,045	0,125	0,212	0,300	0,355	0,500	0,850	1,18
	Residue % (mass fraction)	min.	97	97	97	97	97	97	97	97
Undersize	Sieve size	mm	0,045	0,125	0,212	0,300	0,355	0,500	0,850	1,18
	Through-flow % (mass fraction)	max.	3	3	3	3	3	3	3	3

^a By agreement between the interested parties, abrasives of different particle size ranges may be mixed together. Details of proportions of nominal size, oversize and undersize shall be specified.

EXAMPLE

Abrasive ISO 11126 N/FA-A/G 0,85-2,00