

**Termopihustamine.
Termopihustusseadmete vastavuse
kontrollimine tehnilistele tingimustele**

Thermal spraying - Acceptance inspection of thermal spraying equipment

EESTI STANDARDI EESSÕNA

NATIONAL FOREWORD

<p>Käesolev Eesti standard EVS-EN 1395:1999 sisaldab Euroopa standardi EN 1395:1996 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 1395:1999 consists of the English text of the European standard EN 1395:1996.</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: See Euroopa standard määrab kindlaks tehnilistele tingimustele vastavuse nõuded termopihustusseadmete korral, kaasa arvatud plasma-, kaar- ja leekpihustusseadmed, mida kasutatakse heakvaliteediliste katete pealekandmiseks.</p>	<p>Scope:</p>
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Võtmesõnad: elektrikaared, füüsika, katsed, kvaliteedi kontrollimine, leegid, metallkatted, plasma, termopihustamine, töökojad, varustus, vastuvõetavus

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Descriptors: Thermal spraying, welding, acceptance inspection.

English version

Thermal spraying
**Acceptance inspection
of thermal spraying equipment**

Projection thermiques; contrôle d'acceptation du matériel de projection thermique

Thermisches Spritzen; Abnahmeprüfungen für Anlagen zum thermischen Spritzen

This European Standard was approved by CEN on 1996-02-10.

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 Central Secretariat 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 Central Secretariat has the same status as the official versions.

CEN members are the national standards bodies of Austria, Belgium, Denmark, Finland, France, Germany, Greece, Iceland, Ireland, Italy, Luxembourg, Netherlands, Norway, Portugal, Spain, Sweden, Switzerland and United Kingdom.

CEN

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

Central Secretariat: rue de Stassart 36, B-1050 Brussels

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Foreword

This European Standard has been prepared by Technical Committee CEN/TC 240 'Thermal spraying and thermally sprayed coatings', 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, and conflicting national standards withdrawn, by September 1996 at the latest.

In accordance with the CEN/CENELEC Internal Regulations, 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 United Kingdom.

1 Scope

This European standard specifies requirements for the acceptance inspection of thermal spraying equipment including plasma, arc and flame spraying plants used to produce high-quality sprayed coatings.

2 Normative references

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text, and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references, the latest edition of the publication referred to applies.

EN 1274 Thermal spraying – Powders – Composition – Technical supply conditions

3 Purpose of acceptance inspection

Acceptance inspection as part of a quality assurance system for spraying equipment serves to provide proof, that the equipment is suitable for producing sprayed coatings of uniform quality in particular to satisfy the requirements of this standard.

The European Standard is intended to form the basis of technical delivery conditions.

Proof of the suitability of equipment for thermal spraying is to be provided by the supplier when delivering a spray unit for the first time, but may also be verified by the user as described in clause 6. The values thereby obtained and any other data of significance in deciding on the suitability of the equipment shall be recorded on report sheets or in an inspection report as shown in Annex A, B, C and D. The spraying equipment may be considered adequately designed if all the requirements specified in clause 6 are satisfied in the tests described in clause 7.

4 Conditions for acceptance inspection

Spraying equipment shall comply with the relevant safety specifications. They shall be installed so that the spraying process is not impaired by other production equipment or environmental conditions.

The gas supply provided shall be adequate in volume and purity.

Care shall be taken to ensure that no interference by fluctuations of the main power supply can influence the set electrical values. Every equipment shall be supplied with an operating and maintenance instruction manual.

The equipment shall be tested with the gun in a fixed position and in a manner agreed between purchaser and manufacturer.

5 Designation

Acceptance inspection of thermal spraying equipment shall be designated for example:

Acceptance inspection according to EN 1395.

6 Principles of acceptance inspection

6.1 Plasma spraying equipment

6.1.1 Electrical power

The maximum power level for continuous operation of the plasma spraying system shall be maintained during continuous duty, a precondition for this being that the spraying gun is designed for such performance.