



# SLOVENSKI STANDARD SIST EN ISO 8504-2:2002

01-september-2002

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## Priprava jeklenih podlag pred nanašanjem barv in sorodnih pripravkov - Postopki priprave površine - 2. del: Peskanje z abrazivi (ISO 8504-2:2000)

Preparation of steel substrates before application of paints and related products - Surface preparation methods - Part 2: Abrasive blast-cleaning (ISO 8504-2:2000)

Vorbereitung von Stahloberflächen vor dem Auftragen von Beschichtungsstoffen - Verfahren für die Oberflächenvorbereitung - Teil 2: Strahlen (ISO 8504-2:2000)

Préparation des subjectiles d'acier avant application de peintures et de produits assimilés - Méthodes de préparation des subjectiles - Partie 2: Décapage par projection d'abrasif (ISO 8504-2:2000)

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**Ta slovenski standard je istoveten z: EN ISO 8504-2:2001**

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### **ICS:**

25.220.10	Priprava površine	Surface preparation
87.020	Postopki za nanašanje barvnih premazov	Paint coating processes

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EUROPEAN STANDARD  
NORME EUROPÉENNE  
EUROPÄISCHE NORM

**EN ISO 8504-2**

May 2001

ICS 25.220.10

English version

**Preparation of steel substrates before application of paints and related products - Surface preparation methods - Part 2: Abrasive blast-cleaning (ISO 8504-2:2000)**

Préparation des subjectiles d'acier avant application de peintures et de produits assimilés - Méthodes de préparation des subjectiles - Partie 2: Décapage par projection d'abrasif (ISO 8504-2:2000)

Vorbereitung von Stahloberflächen vor dem Auftragen von Beschichtungsstoffen - Verfahren für die Oberflächenvorbereitung - Teil 2: Strahlen (ISO 8504-2:2000)

This European Standard was approved by CEN on 7 March 2001.

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 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 Management Centre has the same status as the official versions.

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



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COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

**Management Centre: rue de Stassart, 36 B-1050 Brussels**

## Foreword

The text of the International Standard from Technical Committee ISO/TC 35 "Paints and varnishes" of the International Organization for Standardization (ISO) has been taken over as an European Standard by 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 November 2001, and conflicting national standards shall be withdrawn at the latest by November 2001.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Czech Republic, 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 8504-2:2000 has been approved by CEN as a European Standard without any modification.

NOTE: Normative references to International Standards are listed in annex ZA (normative).

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**Annex ZA**  
(normative)**Normative references to international publications with their relevant European publications**

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 (including amendments).

NOTE Where an International Publication has been modified by common modifications, indicated by (mod.), the relevant EN/HD applies.

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN/HD</u>	<u>Year</u>
ISO 8502-2	1992	Preparation of steel substrates before application of paints and related products - Tests for the assessment of surface cleanliness - Part 2: Laboratory determination of chloride on cleaned surfaces	EN ISO 8502-2	1999
ISO 8502-3	1992	Preparation of steel substrates before application of paint and related products - Tests for the assessment of surface cleanliness - Part 3: Assessment of dust on steel surfaces prepared for painting (pressure-sensitive tape method)	EN ISO 8502-2	1999
ISO 8502-9	1998	Preparation of steel substrates before application of paints and related products - Tests for the assessment of surface cleanliness - Part 9: Field method for the conductometric determination of water-soluble salts	EN ISO 8502-2	2000
ISO 8503-1	1988	Preparation of steel substrates before application of paints and related products - Surface roughness characteristics of blast-cleaned steel substrates - Part 1: Specifications and definitions for ISO surface profile comparators for the assessment of abrasive blast-cleaned surfaces	EN ISO 8503-1	1999
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	EN ISO 8503-2	1999

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	EN ISO 11124-1	1997
ISO 11124-2	1993	Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part 2: Chilled-iron grit	EN ISO 11124-2	1997
ISO 11124-3	1993	Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part 3: High-carbon cast-steel shot and grit	EN ISO 11124-3	1997
ISO 11124-4	1993	Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part 4: Low-carbon cast-steel shot	EN ISO 11124-4	1997
ISO 11126-1	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 1: General introduction and classification	EN ISO 11126-1	1997
ISO 11126-3	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 3: Copper refinery slag	EN ISO 11126-3	1997
ISO 11126-4	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 4: Coal furnace slag	EN ISO 11126-4	1997
ISO 11126-5	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 5: Nickel refinery slag	EN ISO 11126-5	1997
ISO 11126-6	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 6: Iron furnace slag	EN ISO 11126-6	1997
ISO 11126-7	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 7: Fused aluminium oxide	EN ISO 11126-7	1997
ISO 11126-8	1993	Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 8: Olivine sand	EN ISO 11126-8	1997

# INTERNATIONAL STANDARD

**ISO**  
**8504-2**

Second edition  
2000-03-01

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## Preparation of steel substrates before application of paints and related products — Surface preparation methods —

Part 2:

### **Abrasive blast-cleaning**

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*Préparation des subjectiles d'acier avant application de peintures et de  
produits assimilés — Méthodes de préparation des subjectiles —*

*Partie 2: Décapage par projection d'abrasif*

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## ISO 8504-2:2000(E)

## 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.

International Standards are drafted in accordance with the rules given in the ISO/IEC Directives, Part 3.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

Attention is drawn to the possibility that some of the elements of this part of ISO 8504 may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights.

International Standard ISO 8504-2 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 8504-2:1992), which has been updated and editorially revised.

ISO 8504 consists of the following parts, under the general title *Preparation of steel substrates before application of paints and related products — Surface preparation methods*:

- Part 1: General principles
- Part 2: Abrasive blast-cleaning
- Part 3: Hand- and power-tool cleaning

Further parts are planned.

Annex A of this part of ISO 8504 is for information only.

## Introduction

The performance of protective coatings of paint and related products applied to steel is significantly affected by the state of the steel surface immediately prior to painting. The principal factors that are known to influence this performance are:

- a) the presence of rust and mill scale;
- b) the presence of surface contaminants, including salts, dust, oils and greases;
- c) the surface profile.

International Standards ISO 8501, ISO 8502 and ISO 8503 have been prepared to provide methods of assessing these factors, while ISO 8504 provides guidance on the preparation methods that are available for cleaning steel substrates, indicating the capabilities of each in attaining specified levels of cleanliness.

These International Standards do not contain recommendations for the protective coating system to be applied to the steel surface. Neither do they contain recommendations for the surface quality requirements for specific situations even though surface quality can have a direct influence on the choice of protective coating to be applied and on its performance. Such recommendations are found in other documents such as national standards and codes of practice. It will be necessary for the users of these International Standards to ensure the qualities specified are

- compatible and appropriate both for the environmental conditions to which the steel will be exposed and for the protective coating system to be used; [SIST EN ISO 8504-2:2002](https://standards.iteh.ai/catalog/standards/sist/e5209d7c-6282-4cf5-8016-99b230830830/iso-8504-2-2002)
- within the capability of the cleaning procedure specified. <https://standards.iteh.ai/catalog/standards/sist/e5209d7c-6282-4cf5-8016-99b230830830/iso-8504-2-2002>

The four International Standards referred to below deal with the following aspects of preparation of steel substrates:

ISO 8501 — *Visual assessment of surface cleanliness*;

ISO 8502 — *Tests for the assessment of surface cleanliness*;

ISO 8503 — *Surface roughness characteristics of blast-cleaned steel substrates*;

ISO 8504 — *Surface preparation methods*.

Each of these International Standards is in turn divided into separate parts.

The primary objective of surface preparation is to ensure the removal of deleterious matter and to obtain a surface that permits satisfactory adhesion of the priming paint to steel. It should also assist in reducing the amounts of contaminants that initiate corrosion.

This part of ISO 8504 describes abrasive blast-cleaning methods. It should be read in conjunction with ISO 8504-1.

Abrasive blast-cleaning is a most effective method for mechanical surface preparation. It is widely applicable because this method of surface preparation has a number of versatile features listed below.

- a) The method allows a high production rate.
- b) The equipment can be stationary or mobile and is adaptable to the objects to be cleaned.