

**SLOVENSKI STANDARD**  
**SIST EN ISO 11124-1:1997****01-december-1997**

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**Priprava jeklenih podlag pred nanašanjem barvnih in sorodnih premazov -  
Specifikacije za kovinske granulate za peskanje - 1. del: Splošna predstavitev in  
razvrstitev (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 (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)

[SIST EN ISO 11124-1:1997](https://standards.iteh.ai/catalog/standards/sist/1da133aa-a655-4ba8-87cf-)

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

**Ta slovenski standard je istoveten z: EN ISO 11124-1:1997**

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**ICS:**

25.220.10 Priprava površine Surface preparation

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EUROPEAN STANDARD

EN ISO 11124-1

NORME EUROPÉENNE

EUROPÄISCHE NORM

January 1997

ICS 87.020

Descriptors: see ISO document

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

The European Standards exist 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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EN ISO 11124-1:1997

## 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 July 1997, and conflicting national standards shall be withdrawn at the latest by July 1997.

According to 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.

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### Endorsement notice

[SIST EN ISO 11124-1:1997](#)

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

INTERNATIONAL  
STANDARD

**ISO**  
**11124-1**

First edition  
1993-12-15

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

**(Part 1: Standards.iteh.ai)**

**General introduction and classification**

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*Préparation des subjectiles d'acier avant application de peintures et de  
produits assimilés — Spécifications pour abrasifs métalliques destinés à  
la préparation par projection —*

*Partie 1: Introduction générale et classification*



Reference number  
ISO 11124-1:1993(E)

**ISO 11124-1:1993(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.

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.

International Standard ISO 11124-1 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*.

ISO 11124 consists of the following parts, under the general title *Preparation of steel substrates before application of paints and related products* — *Specifications for metallic blast-cleaning abrasives*:

- *Part 1: General introduction and classification*
- *Part 2: Chilled-iron grit*
- *Part 3: High-carbon cast-steel shot and grit*
- *Part 4: Low-carbon cast-steel shot*
- *Part 5: Cut steel wire*

At the time of publication of this part of ISO 11124, part 5 was in course of preparation.

Annex A of this part of ISO 11124 is for information only.

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## 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 8501-1<sup>1)</sup> provides photographic examples of the change in appearance imparted to steel when blast-cleaned with different abrasive types.

ISO 8503-2<sup>2)</sup> 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.*

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

## Part 1:

### General introduction and classification

**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.

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## 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.