

SLOVENSKI STANDARD
SIST EN ISO 11124-4:1997**01-december-1997**

**Priprava jeklenih podlag pred nanašanjem barvnih in sorodnih premazov -
Specifikacije za kovinske granulate za peskanje - 4. del: Nizko ogljični litojekleni
sekanci (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
(ISO 11124-4:1993)

Vorbereitung von Stahloberflächen vor dem Auftragen von Beschichtungsstoffen -
Anforderungen an metallische Strahlmittel - Teil 4: Stahlguß mit niedrigem
Kohlenstoffgehalt, kugelig (Schot) (ISO 11124-4:1993)

Préparation des subjectiles d'acier avant application de peintures et de produits
assimilés - Spécifications pour abrasifs métalliques destinés a la préparation par
projection - Partie 4: Grenaille ronde en acier moulé a bas carbone (ISO 11124-4:1993)

Ta slovenski standard je istoveten z: EN ISO 11124-4:1997

ICS:

25.220.10 Priprava površine Surface preparation

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EUROPEAN STANDARD

EN ISO 11124-4

NORME EUROPÉENNE

EUROPÄISCHE NORM

June 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 4:
Low-carbon cast-steel shot (ISO 11124-4:1993)**

Préparation des subjectiles d'acier avant application de peintures et de produits assimilés - Spécifications pour abrasifs métalliques destinés à la préparation par projection - Partie 4: Grenaille ronde en acier moulé à bas carbone (ISO 11124-4:1993)

Vorbereitung von Stahloberflächen vor dem Auftragen von Beschichtungsmitteln - Anforderungen an metallische Strahlmittel - Teil 4: Stahlguß mit niedrigem Kohlenstoffgehalt, kugelig (Shot) (ISO 11124-4:1993)

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This European Standard was approved by CEN on 1997-05-28. 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, Czech Republic, 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

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 December 1997, and conflicting national standards shall be withdrawn at the latest by December 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, Czech Republic, 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
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The text of the International Standard ISO 11124-4:1993 has been approved by CEN as a European Standard without any modification.

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

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.

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN</u>	<u>Year</u>
ISO 4935	1989	Steel and iron - Determination of sulfur content - Infrared absorption method after combustion in an induction furnace	EN 24935	1991
ISO 11125-1	1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 1: Sampling	EN ISO 11125-1	1997
ISO 11125-2	1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 2: Determination of particle size distribution	EN ISO 11125-2	1997
ISO 11125-3	1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 3: Determination of hardness	EN ISO 11125-3	1997
ISO 11125-4	1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 4: Determination of apparent hardness	EN ISO 11125-4	1997
ISO 11125-5	1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 5: Determination of percentage defective particles and of microstructure	EN ISO 11125-5	1997

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ISO 11125-6 1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 6: Determination of foreign matter	EN ISO 11125-6	1997
ISO 11125-7 1993	Preparation of steel substrates before application of paints and related products - Test methods for metallic blast-cleaning abrasives - Part 7: Determination of moisture	EN ISO 11125-7	1997

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INTERNATIONAL
STANDARD

ISO
11124-4

First edition
1993-12-15

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

(Part 4:

Low-carbon cast-steel shot

<https://standards.iteh.ai/catalog/standards/sist/08bedc45-8942-4cb2-93d3-0419b94bfd64/sist-en-iso-11124-4-1997>

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

Partie 4: Grenaille ronde en acier moulé à bas carbone



Reference number
ISO 11124-4:1993(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 11124-4 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*:1997

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.

Annexes A and B of this part of ISO 11124 are for information only.

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

Part 4:

Low-carbon cast-steel shot

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 specifies requirements for 12 grades of low-carbon cast-steel shot abrasive, as supplied for blast-cleaning processes. Values are specified for hardness, density, defect/structural requirements and chemical composition.

The requirements specified in this part of ISO 11124 apply to abrasives supplied in the “new” condition only. They do not apply to abrasives either during or after use.

Test methods for metallic blast-cleaning abrasives are given in the various parts of ISO 11125.

Low-carbon cast-steel shot abrasives are used in both static and site blasting equipment. They are most often selected where a facility exists for recovery and re-use of the abrasive.

NOTES

1 Information on commonly referenced national standards for metallic abrasives and their approximate relationship with ISO 11124 is given in annexes A and B.

2 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 Normative references

The following standards contain provisions which, through reference in this text, constitute provisions of this part of ISO 11124. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this part of ISO 11124 are encouraged to investigate the possibility of applying the most recent editions of the standards indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 439:1982, *Steel and cast iron — Determination of total silicon — Gravimetric method*.

ISO 629:1982, *Steel and cast iron — Determination of manganese content — Spectrophotometric method*.