

STN	Žiarové striekanie Predúprava častí kovových povrchov a dielcov pred žiarovým striekaním	STN EN 13507 03 8731
------------	---	--

Thermal spraying - Pre-treatment of surfaces of metallic parts and components for thermal spraying

Táto norma obsahuje anglickú verziu európskej normy.
This standard includes the English version of the European Standard.

Táto norma bola oznámená vo Vestníku ÚNMS SR č. 12/18

Obsahuje: EN 13507:2018

Oznámením tejto normy sa ruší
STN EN 13507 (03 8731) zo septembra 2010

127682

EUROPEAN STANDARD**EN 13507****NORME EUROPÉENNE****EUROPÄISCHE NORM**

August 2018

ICS 25.220.10; 25.220.20

Supersedes EN 13507:2010

English Version

Thermal spraying - Pre-treatment of surfaces of metallic parts and components for thermal spraying

Projection thermique - Traitement préalable de surface de pièces et composants métalliques pour projection thermiques

Thermisches Spritzen - Vorbehandlung von Oberflächen metallischer Werkstücke und Bauteile für das thermische Spritzen

This European Standard was approved by CEN on 9 April 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.

CEN members are the national standards bodies of 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 United Kingdom.



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

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

EN 13507:2018 (E)

Contents	Page
European foreword	3
1 Scope	4
2 Normative references	4
3 Terms and definitions	4
4 Principles	4
5 Methods of surface preparation	5
5.1 General	5
5.2 Degreasing	5
5.3 Grit blasting	5
5.3.1 Cleanliness	5
5.3.2 Roughness	6
5.3.3 Abrasives	6
5.3.4 Post cleaning after grit blasting	6
5.3.5 Examination of grit blasted surfaces	7
5.4 Threading/grooving	7
5.5 Cleaning by reversed transferred arc	7
5.6 Bond coatings	7
5.7 Precautions for health, safety and environmental protection	7
6 Preheating	7
7 Masking of areas not to be coated	8
8 Effect of pre-treatment on the fatigue strength	8
Bibliography	9

European foreword

This document (EN 13507:2018) 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, at the latest by February 2019, and conflicting national standards shall be withdrawn at the latest by February 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 13507:2010.

This third edition of EN 13507 cancels and replaces EN 13507:2010, which has been technically revised and, in addition to the change in number, contains the following changes:

- update of normative references;
- Revision of subclause 5.6 (Bond coatings).

According to the CEN-CENELEC Internal Regulations, the national standards organisations 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.

EN 13507:2018 (E)**1 Scope**

This document specifies the processing of surface preparation for thermal spraying. Important principles indicated in this European Standard are intended to be taken into consideration when surfaces of metallic parts are to be prepared for thermal spraying. This document applies for production of new parts as well as for the repair of worn parts.

This document does not apply for thermal spraying in the case of protection against atmospheric corrosion by coatings of zinc and/or aluminium and their alloys, for which EN ISO 2063-1:2017 and EN ISO 2063-2:2017 apply.

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.

EN ISO 8501-1, *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 (ISO 8501-1)*

EN ISO 11124-1, *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)*

EN ISO 11124-2, *Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part 2: Chilled-iron grit (ISO 11124-2)*

EN ISO 11126-1, *Preparation of steel substrates before application of paints and related products - Specifications for non-metallic blast-cleaning abrasives - Part 1: General introduction and classification (ISO 11126-1)*

koniec náhľadu – text ďalej pokračuje v platenej verzii STN