

<b>STN</b>	<b>Príprava oceľových podkladov pred nanesením náterových látok a podobných výrobkov</b> <b>Špecifikácia kovových prostriedkov na abrazívne čistenie</b> <b>Časť 2: Piesok z liatej ocele (ISO 11124-2: 2018)</b>	<b>STN</b> <b>EN ISO 11124-2</b>  03 8234
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Preparation of steel substrates before application of paints and related products - Specifications for metallic blast-cleaning abrasives - Part 2: Chilled-iron grit (ISO 11124-2:2018)

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. 02/19

Obsahuje: EN ISO 11124-2:2018, ISO 11124-2:2018

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EUROPEAN STANDARD

EN ISO 11124-2

NORME EUROPÉENNE

EUROPÄISCHE NORM

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Supersedes EN ISO 11124-2:1997

English Version

Preparation of steel substrates before application of paints  
and related products - Specifications for metallic blast-  
cleaning abrasives - Part 2: Chilled-iron grit (ISO 11124-  
2:2018, Corrected version 2018-12)

Préparation des subjectiles d'acier avant application de  
peintures et de produits assimilés - Spécifications pour  
abrasifs métalliques destinés à la préparation par  
projection - Partie 2: Grenaille angulaire en fonte  
trempée (ISO 11124-2:2018, Version corrigée 2018-  
12)

Vorbereitung von Stahloberflächen vor dem Auftragen  
von Beschichtungsstoffen - Anforderungen an  
metallische Strahlmittel - Teil 2: Hartguss, kantig (Grit)  
(ISO 11124-2:2018)

This European Standard was approved by CEN on 12 August 2018.

This European Standard was corrected and reissued by the CEN-CENELEC Management Centre on 19 December 2018.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
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**EN ISO 11124-2:2018 (E)**

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## **European foreword**

This document (EN ISO 11124-2:2018) has been prepared by Technical Committee ISO/TC 35 "Paints and varnishes" in collaboration with 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 March 2019, and conflicting national standards shall be withdrawn at the latest by March 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 ISO 11124-2:1997.

According to the CEN-CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, 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.

## **Endorsement notice**

The text of ISO 11124-2:2018, Corrected version 2018-12 has been approved by CEN as EN ISO 11124-2:2018 without any modification.

# INTERNATIONAL STANDARD

# ISO 11124-2

Second edition  
2018-08

Corrected version  
2018-12

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

### Part 2: Chilled-iron grit

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

*Partie 2: Grenaille angulaire en fonte trempée*



Reference number  
ISO 11124-2:2018(E)

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**ISO 11124-2:2018(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.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

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Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation on the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT) see the following URL: [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

This document 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 11124-2:1993), which has been technically revised.

The main changes compared to the previous edition are as follows:

- Annex A and Bibliography have been removed.

A list of all parts in the ISO 11124 series can be found on the ISO website.

This corrected version of ISO 11124-2:2018 incorporates the following correction:

- Missing values in cells of Table 1 have been reinserted.



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

## Part 2: Chilled-iron grit

**WARNING — Equipment, materials and abrasives used for surface preparation can be hazardous. It is important to ensure that adequate instructions are given and that all required precautions are exercised.**

### 1 Scope

This document specifies requirements for 12 grades of chilled-iron grit abrasives, as supplied for blast-cleaning processes. It specifies ranges of particle sizes, together with corresponding grade designations. Values are specified for hardness, density, defect/structural requirements and chemical composition.

The requirements specified in this document 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.

Chilled-iron grit 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.

**NOTE** Although this document 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.

### 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.

ISO 9556, *Steel and iron — Determination of total carbon content — Infrared absorption method after combustion in an induction furnace*

ISO 11125-1, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 1: Sampling*

ISO 11125-2, *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*

ISO 11125-3, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 3: Determination of hardness*

ISO 11125-4, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 4: Determination of apparent density*

ISO 11125-5, *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*

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ISO 11125-6, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 6: Determination of foreign matter*

ISO 11125-7, *Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 7: Determination of moisture*

**koniec náhľadu – text ďalej pokračuje v platenej verzii STN**