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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

The European Standard EN ISO 11124-3:1997 has the status of a
British Standard

ICS 25.220.10; 87.020

**BS EN ISO
11124-3:1997
BS 7079-E3:
1994**

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Amendment No. 1 to
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11124-3:1997)*

Committees responsible for this British Standard

The preparation of this British Standard was entrusted by the Surface Treatments and Coatings Standards Policy Committee (STC/-) to Technical Committee STC/21, upon which the following bodies were represented:

- Association of Consulting Engineers
- British Chemical Engineering Contractors' Association
- British Coatings Federation Ltd.
- British Constructional Steelwork Association Ltd.
- British Grit Association
- British Railways Board
- British Steel Industry
- Department of Transport
- Electricity Association
- Institute of Corrosion
- National Federation of Painting and Decorating Contractors
- Oil and Colour Chemists' Association
- Paint Research Association
- Royal Society of Chemistry

This British Standard, having been prepared under the direction of the Surface Treatments and Coatings Standards Policy Committee, was published under the authority of the Standards Board and comes into effect on 15 March 1994

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National foreword

This British Standard has been prepared by Technical Committee STC/21 and is the English language version of EN ISO 11124-3:1997 *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*, published by the European Committee for Standardization (CEN). It is identical with ISO 11124-3:1993, published by the International Organization for Standardization (ISO).

International Standard ISO 11124-3 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.

The other parts of BS EN ISO 11124 are:

- *Part 1: General introduction and classification;*
- *Part 2: Chilled-iron grit;*
- *Part 4: Low-carbon cast-steel shot.*

Together with Part 4, this Part of BS EN ISO 11124 supersedes BS 2451:1963, which is withdrawn.

Cross-references

The British Standards which implement international or European publications referred to in this document may be found in the BSI Standards Catalogue under the section entitled “International Standards Correspondence Index”, or by using the “Find” facility of the BSI Standards Electronic Catalogue. Attention is drawn to Annex ZA, which gives the European Standards that correspond to the International Standards referred to.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

Compliance with a British Standard does not of itself confer immunity from legal obligations.

Summary of pages

This document comprises a front cover, an inside front cover, pages i and ii, the EN ISO title page, pages 2 to 8, an inside back cover and a back cover.

This standard has been updated (see copyright date) and may have had amendments incorporated. This will be indicated in the amendment table on the inside front cover.

English version

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

(ISO 11124-2:1993)

Préparation des subjectiles d'acier avant
application de peintures et de produits
assimilés — Spécifications pour abrasifs
métalliques destinés à la préparation par
projection —
Partie 3: Grenaille ronde et angulaire en acier
moulé à haut carbone
(ISO 11124-3:1993)

Vorbereitung von Stahloberflächen vor dem
Auftragen von Beschichtungsstoffen —
Anforderungen an metallische Strahlmittel —
Teil 3: Stahlfluß mit hohem Kohlenstoffgehalt,
kugelig und kantig (shot und Grit)
(ISO 11124-3:1993)

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.

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CEN

European Committee for Standardization
Comité Européen de Normalisation
Europäisches Komitee für Normung

Central Secretariat: 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 a 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 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.

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

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.

1 Scope

This part of ISO 11124 specifies requirements for 14 grades of high-carbon cast-steel shot and 12 grades of high-carbon cast-steel grit, 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.

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

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

NOTE 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*.

ISO 4935:1989, *Steel and iron — Determination of sulfur content — Infrared absorption method after combustion in an induction furnace*.

ISO 9556:1989, *Steel and iron — Determination of total carbon content — Infrared absorption method after combustion in an induction furnace*.

ISO 10714:1992, *Steel and iron — Determination of phosphorus content — Phosphovanadomolybdate spectrophotometric method*.

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*.

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*.

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*.

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 density*.

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*.

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*.

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*.

3 Definitions

For the purposes of this part of ISO 11124, the following definitions apply.

3.1

high-carbon cast-steel shot

a metallic blast-cleaning abrasive produced by a casting process in which molten high-carbon steel is formed into shot (see also 3.3) by means of an atomization process

3.2

high-carbon cast-steel grit

a metallic blast-cleaning abrasive obtained by crushing various high-carbon cast-steel shot sizes into sharp-edged angular particles

3.3 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

3.4 grit

particles that are predominantly angular, that have fractured faces and sharp edges and that are less than half round in shape

3.5 Defect

A fault or weakness in an abrasive which, if present at or above a given level, may be detrimental to the performance characteristics of the abrasive (see Table 3).

3.5.1 void

a smooth-surfaced internal cavity considered undesirable when greater than 10 % of the cross-sectional area of a particle

3.5.2 shrinkage defect

an internal cavity with a rough dendritic surface or a zone of microporosity, considered undesirable when greater than 40 % of the cross-sectional area of a particle

3.5.3 crack

a linear discontinuity that has a length-to-width ratio of 3 : 1 or greater, that extends over more than 20 % of the diameter or shortest dimension of a particle and that is radial in direction

3.6 foreign matter

any material or particles mixed with the abrasive which are not attached to the abrasive particles and which are nonmagnetic

4 Designation of abrasives

High-carbon cast-steel shot and grit shall be identified by "Abrasive ISO 11124" and the abbreviation "M/HCS" indicating metallic, high-carbon cast-steel abrasive. The symbol "S" or "G" shall follow to indicate the required particle shape of the shot or grit as purchased. The designation shall be completed by a 3-digit number denoting the grade, or nominal particle size, required. If alternative hardnesses of abrasive are available, the particular Vickers hardness (HV) range required shall be specified (see example 2).

EXAMPLE 1

Abrasive ISO 11124 M/HCS/S140

denotes an abrasive of the metallic, high-carbon cast-steel type, complying with the requirements of this part of ISO 11124, of particle shape shot and grade 140 (i.e. nominal particle size 1,40 mm).

EXAMPLE 2

Abrasive ISO 11124 M/HCS/G140/570-710HV

denotes an abrasive of the metallic, high-carbon cast-steel type, complying with the requirements of this part of ISO 11124, of particle shape grit and grade 140 (i.e. nominal particle size 1,40 mm), and with a hardness range of 570 HV to 710 HV.

It is essential that this full product designation is quoted on all orders.

NOTE 3 Grade requirements and codes are specified in Table 1 and Table 2. The grade code is based on a number indicating the approximate middle of the particle size range, or nominal diameter, for each grade, expressed in millimetres ϕ 100.

NOTE 4 Annex A provides guidance on approximately equivalent grades and codings in other commonly referenced national standards for cast-metal abrasives.

5 Sampling

Sampling procedures shall be as specified in ISO 11125-1.

6 Requirements for high-carbon cast-steel shot and grit abrasives

The requirements for high-carbon cast-steel shot and grit abrasives shall be as specified in Table 3.

7 Package identification and lot traceability

All supplies shall be clearly marked and identified using the designation system specified in clause 4. The unit of sale, i.e. pallet, drum, box, etc., shall be clearly labelled with the full product coding, including hardness range, if applicable.

Sub-units, i.e. bags, shall be marked with the particle shape and grade codes.

NOTE 5 Inclusion of additional marking to allow product traceability to a particular production period or lot is strongly recommended. Traceability references should be included at least at the pallet, drum or box level of package marking.

8 Information to be provided by the manufacturer or supplier

The manufacturer or supplier shall provide, if requested, a test report detailing results for any relevant property as determined by the appropriate method specified in Table 3.

**Table 1 — Screening specifications by grade — High-carbon
cast-steel shot — Cumulative % retained**

Grade code	Sieve mesh aperture, mm																			
	4,75	4,00	3,35	2,80	2,36	2,00	1,70	1,40	1,18	1,00	0,85	0,71	0,60	0,50	0,425	0,355	0,300	0,250	0,180	0,125
S400	0		> 90	> 97																
S300		0		> 90	> 97															
S280			0		> 90	> 97														
S240				0		> 85	> 97													
S200					0		> 85	> 97												
S170						0		> 85	> 97											
S140						0	< 5		> 85	> 96										
S120							0	< 5		> 85	> 96									
S100								0	< 5		> 85	> 96								
S080									0	< 5		> 85	> 96							
S070										0	< 10		> 85	> 97						
S060											0	< 10			> 85	> 97				
S040													0	< 10			> 80		> 90	
S030															0	< 10			> 80	> 90

NOTE For convenience, a similar table is used in most parts of ISO 11124. Not all sieve mesh apertures are relevant in each case.

**Table 2 — Screening specifications by grade — High-carbon
cast-steel grit — Cumulative % retained**

Grade code	Sieve mesh aperture, mm																		
	2,80	2,36	2,00	1,70	1,40	1,18	1,00	0,85	0,71	0,60	0,50	0,425	0,335	0,300	0,250	0,180	0,125	0,075	0,045
G240	0		> 80	> 90															
G200		0		> 80	> 90														
G170			0		> 80	> 90													
G140				0		> 75	> 85												
G120					0		> 75		> 85										
G100						0			> 70			> 80							
G070							0					> 70		> 80					
G050									0					> 65		> 75			
G030												0				> 65	> 75		
G020														0			> 60	> 70	
G010																0		> 55	> 65
G005																	0		> 20

NOTE For convenience, a similar table is used in most parts of ISO 11124. Not all sieve mesh apertures are relevant in each case.

Table 3

Property	Requirement	Test method																						
Grade size	See Tables 1 and 2.	ISO 11125-2																						
Hardness	90 % of the particles tested shall have a hardness value within one of the ranges specified below: <i>Standard hardnesses:</i> <table><tr><td></td><td>Hardness</td></tr><tr><td>Shot</td><td>390 HV to 530 HV</td></tr><tr><td>Grit</td><td>390 HV to 530 HV</td></tr><tr><td></td><td>470 HV to 610 HV</td></tr><tr><td></td><td>570 HV to 710 HV</td></tr><tr><td></td><td>700 HV minimum</td></tr></table> <i>Special hardnesses (shot and grit):</i> Other hardness ranges can be specified by the purchaser, with a minimum of 90 % of the particles having a minimum range of approximately 140 HV. Metallic abrasives sometimes contain internal shrinkage defects or voids which remain undetected beneath the surface in a mounted and polished sample. These hidden cavities cause a non-uniform hardness indentation and give an erroneous hardness reading. These indentations shall be ignored.		Hardness	Shot	390 HV to 530 HV	Grit	390 HV to 530 HV		470 HV to 610 HV		570 HV to 710 HV		700 HV minimum	ISO 11125-3										
	Hardness																							
Shot	390 HV to 530 HV																							
Grit	390 HV to 530 HV																							
	470 HV to 610 HV																							
	570 HV to 710 HV																							
	700 HV minimum																							
Apparent density	min. 7,0 ⋄ 10 ³ kg/m ³ (7,0 kg/dm ³)	ISO 11125-4																						
Defects (see 3.5)	Defects present in the particles examined shall not exceed the following levels: <table><tr><td>Particle shape</td><td></td></tr><tr><td>a) Shot</td><td>max. 5 % non-round</td></tr><tr><td>b) Grit</td><td>max. 10 % shot or greater than half-round for grit up to 700 HV, max. 5 % for grit above 700 HV</td></tr><tr><td>Voids</td><td>max. 10 %</td></tr><tr><td>Shrinkage defect</td><td>max. 10 %</td></tr><tr><td>Cracks</td><td></td></tr><tr><td>a) Shot</td><td>max. 15 %</td></tr><tr><td>b) Grit</td><td>max. 40 %</td></tr><tr><td>Total defects</td><td></td></tr><tr><td>a) Shot</td><td>max. 20 %</td></tr><tr><td>b) Grit</td><td>max. 40 %</td></tr></table>	Particle shape		a) Shot	max. 5 % non-round	b) Grit	max. 10 % shot or greater than half-round for grit up to 700 HV, max. 5 % for grit above 700 HV	Voids	max. 10 %	Shrinkage defect	max. 10 %	Cracks		a) Shot	max. 15 %	b) Grit	max. 40 %	Total defects		a) Shot	max. 20 %	b) Grit	max. 40 %	ISO 11125-5
Particle shape																								
a) Shot	max. 5 % non-round																							
b) Grit	max. 10 % shot or greater than half-round for grit up to 700 HV, max. 5 % for grit above 700 HV																							
Voids	max. 10 %																							
Shrinkage defect	max. 10 %																							
Cracks																								
a) Shot	max. 15 %																							
b) Grit	max. 40 %																							
Total defects																								
a) Shot	max. 20 %																							
b) Grit	max. 40 %																							
Particles with more than one of the above defects shall be counted only once in this total.																								
Foreign matter (including slag)	max. 1 % (m/m)	ISO 11125-6																						
Structure	Cast-steel shot and grit abrasives shall have a uniform martensite and/or bainite microstructure, tempered to a degree consistent with the hardness range, with fine, well-distributed carbides, if any. Partial decarburization, carbide networks and interdendritic grain boundary segregation with high-temperature transformation products such as pearlite are undesirable. No more than 15 % of the particles tested shall have undesirable microstructure.	ISO 11125-5																						

Table 3

Property	Requirement	Test method
Chemical composition	Carbon 0,80 % (m/m) to 1,2 % (m/m)	ISO 9556
	Manganese 0,35 % (m/m) to 1,2 % (m/m)	ISO 629
	Silicon min. 0,4 % (m/m)	ISO 439
	Sulfur max. 0,05 % (m/m)	ISO 4935
	Phosphorus max. 0,05 % (m/m)	ISO 10714
	The manganese content shall be sufficiently high to achieve the required hardness throughout the section of all particles.	
Moisture	max. 0,2 % (m/m) NOTE It is essential that cast-steel shot and grit abrasives are supplied and used in a dry condition. They should be stored indoors in dry surroundings to prevent condensation, rusting and deterioration of the abrasive, rendering it unsuitable for use.	ISO 11125-7

Annex A (informative)

Approximately equivalent codings for shot and grit abrasives

Commonly referenced national standards for metallic abrasives are based on different coding systems for particle size range or grade.

Approximately equivalent codings in some of these national standards are shown in Table A.1 and the nearest equivalent codings in ISO 11124 are shown alongside.

This list is purely informative and should not be taken as indicating that grades are equal. It covers the full range of ISO 11124 codings. This part of ISO 11124 may not contain all the codings listed.

ISO 11124 size limits are identical with those specified in SAE J444:1984.

Table A.1

	SAE J444:1984	BS 2451:1963	DIN 8201 Teil 2:1985	ISO Coding
Shot	S1320	S1320	—	S400
	S1110	S1110	—	S300
	S930	S950	—	S280
	S780	S800	2,0 to 2,8	S240
	S660	S660	1,6 to 2,24	S200
	S550	S550	1,25 to 2,0	S170
	S460	S470	—	S140
	S390	S390	1,0 to 1,6	S120
	S330	S340	0,8 to 1,25	S100
	S280	—	—	S080
	S230	S240	0,6 to 1,0	S070
	S170	S170	0,4 to 0,8	S060
	S110	S120	0,3 to 0,6	S040
	S70	S070	0,2 to 0,4	S030
			DIN 6201 Teil 3:1985	
Grit	—	G95	—	—
	G10	G80	2,0 to 2,8	G240
	G12	G66	1,6 to 2,24	G200
	G14	G55	1,25 to 2,0	G170
	G16	G47	1,0 to 1,6	G140
	G18	G39	1,0 to 1,6	G120
	G25	G34	0,8 to 1,25	G100
	G40	G24/G17	0,6 to 1,0/0,4 to 0,8	G070
	G50	G12	0,3 to 0,6	G050
	G80	G07	0,2 to 0,4	G030
	G120	G05	0,16 to 0,3	G020
	G200	G02	0,1 to 0,2	G010
	G325	G02	—	G005
NOTE "S" signifies shot, i.e. round particle form. "G" signifies grit, i.e. angular particle form.				

Annex B (informative)

Bibliography

Commonly referenced national standards for metallic abrasives are as follows:

- [1] BS 2451:1963, *Specification for chilled-iron shot and grit.*
- [2] DIN 8201 Teil 1:1985, *Feste Strahlmittel; Einteilung, Bezeichnung.*
- [3] DIN 8201 Teil 2:1985, *Feste Strahlmittel; metallisch, gegossen, Kornform kugelig.*
- [4] DIN 8201 Teil 3:1985, *Feste Strahlmittel; metallisch, gegossen, Kornform kantig.*
- [5] DIN 8201 Teil 4:1985, *Feste Strahlmittel; Stahldrahtkorn.*
- [6] JIS G5903:1975, *Cast shot and grit.*
- [7] SAE J444:1984, *Cast-shot and grit size specification for peening and cleaning.*
- [8] SAE J827:1990, *Cast steel shot.*
- [9] SAE J441:1987, *Cut wire shot.*

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.

Publication	Year	Title	EN	Year
ISO 4935	1989	<i>Steel and iron — Determination of sulfur content — Infrared absorption method after combustion in an induction furnace</i>	EN 24935	1991
ISO 11125-1	1993	<i>Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 1: Sampling</i>	EN ISO 11125-1	1997
ISO 11125-2	1993	<i>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</i>	EN ISO 11125-2	1997
ISO 11125-3	1993	<i>Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 3: Determination of hardness</i>	EN ISO 11125-3	1997
ISO 11125-4	1993	<i>Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 4: Determination of apparent hardness</i>	EN ISO 11125-4	1997
ISO 11125-5	1993	<i>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</i>	EN ISO 11125-5	1997
ISO 11125-6	1993	<i>Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 6: Determination of foreign matter</i>	EN ISO 11125-6	1997
ISO 11125-7	1993	<i>Preparation of steel substrates before application of paints and related products — Test methods for metallic blast-cleaning abrasives — Part 7: Determination of moisture</i>	EN ISO 11125-7	1997

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