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**NATIONAL STANDARD OF THE
PEOPLE'S REPUBLIC OF CHINA**

GB/T 13288.4-2013

**Preparation of steel substrates before application of paints and related products --
Surface roughness characteristics of blast-cleaned substrates -- Part 4: Method for the
calibration of ISO surface profile comparator and for the determination of surface**

涂覆涂料前钢材表面处理 喷射清理后的钢材表面粗糙度特性 第4部分：ISO表面
粗糙度比较样块的校准和表面粗糙度的测定方法 触针法

(English Translation)

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Foreword

GB/T 13288 "steel substrates before application of paints and spray cleaned steel surface roughness characteristics" is divided into the following sections.

- Part 1. Technical requirements and definitions used to assess post-blast cleaning of steel surface roughness ISO roughness comparison sample block;
- Part 2. Determination after abrasive blast cleaning of steel surface roughness comparison specimens class method;
- Part 3. Calibration and surface roughness measurement method ISO surface roughness comparison specimens microscope focusing method;
- Part 4. ISO calibration of surface roughness and surface roughness comparison specimens measuring method stylus method;
- Part 5. Determination of surface roughness Replica tape method.

This section GB/T Part of 413,288.

This section drafted in accordance with GB/T 1.1-2009 given rules.

This section uses the translation method identical with ISO 8503-4. 1988 "before application of paints and surface treatment of steel blast cleaning of steel surface roughness Roughness properties - Part 4. ISO calibration of surface roughness and surface roughness measurement method stylus Law "comparative sample block.

Consistency correspondence between this part of international documents and normative references of our files are as follows.

- GB/T 5206 (all parts) Glossary [ISO 4618 (all parts)]
- GB/T 13288.1-2008 steel substrates before application of paints and steel surface roughness characteristics of blast - cleaned first Part 1. Technical requirements for assessing post-blast cleaning of steel surface roughness of ISO surface profile comparators and definitions (ISO 8503-1. 1988, IDT)
- GB/T 13288.2-2011 steel surface blast cleaned steel substrates before application of

paints roughness characteristics Part 2. Part 2. Determination after abrasive blast cleaning of steel surface roughness comparison specimens grade method (ISO 8503-2. 1988, IDT) Spray steel surface treatment after cleaning --- GB/T 13288.3-2009 steel substrates before application of paints and roughness characteristics Part 3. Calibration and surface roughness measurement method ISO surface roughness comparison specimens focus microscope method (ISO 8503-3. 1988, IDT)

--- GB/T 18839.2-2002 steel substrates before application of paints and surface treatment method - Part 2. Abrasive blast - cleaning (ISO 8504-2:2000, MOD) this part is proposed by the China State Shipbuilding Corporation.

This part of the National Standardization Technical Committee before painting and metal surface treatment and painting processes Technical Committee paint pigment (SAC/TC5/SC6) centralized.

This section is drafted. 11th Institute of China Shipbuilding Industry, Technical and Economic Research Institute of China Shipbuilding Industry, MCC Baosteel Technology Services Limited.

1 Scope

GB/T 13288 provisions of this part of the GB/T 13288.1 surface roughness comparators for calibration and surface roughness Stylus assay.

This section GB/T 13288 also apply to clean up after injection, the average peak-valley difference in $Ry5 = 20\mu m \sim 200\mu m$ range of flat steel Determination of surface roughness or a copy. Measurements can be blast-cleaned surface area representative, if not measured directly on the surface, can be measured (see Appendix C) on the surface of the copy.

Note: If desired, can also be used to assess other substrate surface roughness by abrasive blast cleaning.

An alternative method, see ISO 8503-3.

2 Normative references

The following documents for the application of this document is essential. For dated references, only the dated version suitable for use herein Member. For undated references, the latest edition (including any amendments) applies to this document.

ISO 3274 with a surface roughness measurement instrument Roughness law conversion method contacts the contact roughness tester, the system M (Instruments for the measurement of surface roughness by the profile method-Contact transformation-Contact profile meters, system M) ISO 4287-1 Surface roughness - Terminology - Part 1. Surface and reagent preparation (Surface roughness-Terminology-Part 1. Surface and its parameters) ISO 4618 paints and varnishes - Vocabulary (Paints and varnishes-Vocabulary) Calibration

Standard ISO 5436 standard stylus instrument types, calibration and use
(Calibrationspecimens-Stylusinstru-ments-Types, calibrationanduseofspecimens) Steel
surface roughness characteristics - Part 1 ISO 8503-1 coated front surface coating of steel
blast - cleaning. abrasive jet Requirements and definitions
(Preparationofsteelsubstratesbeforeapplication clean up after the steel surface roughness
comparison specimens of ISO
ofpaintsandrelatedproducts-Surfaceroughnesscharacteristicsofblast-cleanedsteelsubstrates
-Part 1.

SpecificationsanddefinitionsforISO
surfaceprofilecomparatorsfortheassessmentofabrasiveblast-cleanedsurfaces) Steel surface
roughness characteristics - Part 2 ISO 8503-2 coated front surface coating of steel blast -
cleaning. abrasive jet After cleaning up the steel surface roughness rating - comparison
specimens Act (Preparationofsteelsubstratesbeforeapplicationof
paintsandrelatedproducts-Surfaceroughnesscharacteristicsofblast-cleanedsteelsubstrates-
Part 2.

Methodforthegradingofsurfaceprofileofabrasiveblast-cleanedsteel-Comparatorprocedure)
Steel surface roughness characteristics - Part 3 ISO 8503-3 coated front surface coating of
steel blast - cleaning. ISO surface Calibration and surface roughness comparison
specimens roughness measuring method microscope focusing method
(Preparationofsteelsubstrates