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

GB/T 13288.5-2009

**Preparation of steel substrates before application of paints and related products
-- Surface roughness characteristics of blast-cleaned steel substrates -- Part 5:
Replica tape method for the determination of the surface profile**

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5部分：表面粗糙度的测定方法 复制带法

(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 for the Assessment of blast - cleaned steel surface roughness of ISO surface profile comparators and definition;

--- 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 13288 Part 5.

This section identical with ISO 8503-5:2003 "before application of paints and surface-treated steel abrasive blast cleaning of steel surface roughness special Part 5. Determination of surface roughness Replica tape method "(in English).

This section is equivalent translation ISO 8503-5:2003.

For ease of use, this section made the following editorial changes.

--- "This International Standard" be replaced by "this section";

--- With a decimal point instead of a comma as the decimal point, ",";

--- With a comma "," instead of a comma as described, ",";

--- Deleted international standard directory, foreword and introduction.

Appendix A of this section and Appendix B is an informative annex.

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 drafted by. China Shipbuilding Industry Corporation, Institute XI, China Shipbuilding Technology and Economy Research Institute, Shandong Kai Tai Metal Abrasive Co., Ltd.

1 Scope

This section GB/T 13288 specifies the press ISO 8504-2 given abrasive blast cleaning methods to clean the steel surface roughness now Field assays. This method is used to copy tape and its ancillary gauges on the front surface coating roughness measurements in the field.

This section applies to a given size (or thickness) of the corresponding range replication roughness measuring tape. With a copy of the specifications currently commercially available Roughness measurement range is the average peak height of 20 μ m ~ 115 μ m. This section applies to metallic or nonmetallic abrasive blasting to clean up the table after Determination of surface roughness.

2 Normative references

The following documents contain provisions which, through reference GB/T 13288 in this section constitute provisions of this section. For dated reference documents Member, all subsequent amendments (not including errata content) or revisions do not apply to this section, however, encouraged to reach under this section Parties to research agreement to use the latest versions of these documents. For undated reference documents, the latest versions apply to this section.

Part 1 Steel Surface roughness characteristics of blast - cleaned steel substrates before GB/T 13288.1-2008 coated paint Score. used to assess the technical requirements and definitions (ISO 8503-1 after blast - cleaned steel surface roughness ISO surface roughness comparison specimens of.

1988, IDT)

Part 3 of the steel surface roughness characteristics of blast - cleaned steel substrates before GB/T 13288.3-2009 coated paint Score. ISO calibration and surface roughness comparison specimens surface roughness measuring method microscope focusing method (ISO 8503-3. 1988, IDT) ISO 4618 Paints and varnishes - Terms and definitions ISO 8503-4 steel surfaces coated with paint spray steel surface treatment after cleaning roughness characteristics - Part 4. ISO table Calibration and surface roughness comparison specimens surface roughness measuring method stylus method ISO 8504-21) before application of paints and surface treatment of steel surface treatment method - Part 2.

Abrasive blast - cleaning

3 Terms and Definitions

GB/T 13288.1-2008 and terms and definitions established ISO 4618 applies to GB/T 13288 in this section.

1) GB/T 18839.2-2002 is equivalent to ISO 8504-2:2000.

Principle 4

The surface of the film is a microporous plastic films with copy compressible layer, this layer of thin film coating in an extremely uniform thickness ($50\mu\text{m} \pm 2\mu\text{m}$) of Polyester sheet surface. When subjected to a hard surface extrusion, microporous plastic membrane collapses about 25% of the initial thickness.

Note 1: When the transfer film plated with thin (80nm), the plastic, metal can reflect light, such as indium, the surface can be reproduced by an optical interferometric imaging Meter to test. When copying a similar plastic film coating, a thin layer of metal can be transmitted electrons, such as gold, platinum or palladium, the surface through an electron microscope the study.

Note 2: This test method reflects the "average maximum peak-valley height roughness." Since roughness probe slight translation in a replication surface, instrument the results measured by the average maximum and arithmetic mean different.

GB/T 13288.5-2009/ISO 8503-5:2003