

# DIN EN ISO 14921:2011-04 (E)

## Thermal spraying - Procedures for the application of thermally sprayed coatings for engineering components (ISO 14921:2010)

---

<b>Contents</b>		<b>Page</b>
Foreword .....		3
Introduction .....		4
1	Scope .....	5
2	Normative references .....	5
3	Terms and definitions .....	5
4	Component and coating design considerations .....	5
4.1	General .....	5
4.2	Pre-inspection in the case of repair .....	6
4.3	Component substrate .....	6
4.4	Coating .....	6
5	Preliminary machining by turning, milling, or grinding .....	7
6	Masking .....	7
7	Methods of surface preparation .....	7
8	Thermal spraying .....	8
9	Inspection after spraying .....	8
10	Sealing .....	8
11	Finishing .....	8
12	Final inspection .....	8
13	Documentation .....	9
Annex A (informative) Flow chart for assessment of suitability of thermal spraying .....		10
Annex B (informative) Check list for evaluation of the most suitable coating system for the intended purpose .....		11
Annex C (informative) Record for the applied thermal spray procedure .....		12
Bibliography .....		16