



National Standards Authority of Ireland

IRISH STANDARD

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ICS 01.080.30
25.220.20

**THERMAL SPRAYING - THERMALLY
SPRAYED COATINGS - SYMBOLIC
REPRESENTATION ON DRAWINGS**

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EUROPEAN STANDARD

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English version

Thermal spraying - Thermally sprayed coatings - Symbolic representation on drawings

Projection thermique - Revêtements appliqués par
projection thermique - Représentation symbolique sur les
dessins

Thermisches Spritzen - Thermisch gespritzte Schichten -
Symbolische Darstellung in Zeichnungen

This European Standard was approved by CEN on 13 September 2004.

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.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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Foreword

This document (EN 14665:2004) has been prepared by Technical Committee CEN/TC 240 “Thermal spraying and thermally sprayed coatings”, 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of an identical text or by endorsement, at the latest by May 2005, and conflicting national standards shall be withdrawn at the latest by May 2005.

This document includes a Bibliography.

According to the CEN/CENELEC Internal Regulations, the national standards organizations of the following countries are bound to implement this European Standard: Austria, Belgium, Cyprus, Czech Republic, Denmark, Estonia, Finland, France, Germany, Greece, Hungary, Iceland, Ireland, Italy, Latvia, Lithuania, Luxembourg, Malta, Netherlands, Norway, Poland, Portugal, Slovakia, Slovenia, Spain, Sweden, Switzerland and United Kingdom.

EN 14665:2004 (E)

1 Scope

This document specifies how the symbolic representation of thermally sprayed coatings has to be indicated on drawings.

2 Normative references

The following referenced documents are indispensable for the application 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.

EN 1274:2004, *Thermal spraying — Powders — Composition — Technical supply conditions*.

EN ISO 14919, *Thermal spraying — Wires, rods and cords for flame and arc spraying — Classification — Technical supply conditions (ISO 14919:2001)*.

3 General

Coatings may be indicated with the general recommendations for technical drawings. To apply this symbolic representation will make sense in cases, where the thermally sprayed coating is very thin and/or may be built up by several dissimilar coatings one upon another.

The symbolic representation shall give clearly all necessary indications regarding the specific coating to be obtained without over-burdening the drawing with notes or showing an additional view or detail enlargement.

This symbolic representation includes an elementary symbol and one or more supplementary symbols and further complementary indications.

If a large number of instructions for producing the coating have to be mentioned, it is recommended to indicate the specific instructions on the drawing or to define them in a separate parts list, if applicable (see Figures 6 and 7).

4 Symbols

The elementary symbol shall indicate, that this process deals with thermal spraying.

The following information shall be given by supplementary symbols:

- type of coating (bond or top coat);
- the spraying process and subsequent treatments.

The following requirements may be defined by further additional instructions:

- the coating thickness needed or the final coating thickness machined, respectively;
- the spray material to be used;
- surface condition;
- post-treatments of coating;
- a technical specification, which defines requirements necessary to complete the coating.

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