

PSPC 海水压载舱钢板预处理要求

一、建议原材料

车间底漆：TH-2 型硅酸锌车间底漆（溧阳产）

钢级		底漆颜色
一般强度船体结构用钢	例：A、D 等	灰色
高强度船体结构用钢	例：AH32、 DH36 等	蓝色

钢砂：钢丸、钢丝头： 粒径：1.2~1.4mm ， 可溶性盐分（NaCl）不大于 50mg/m²


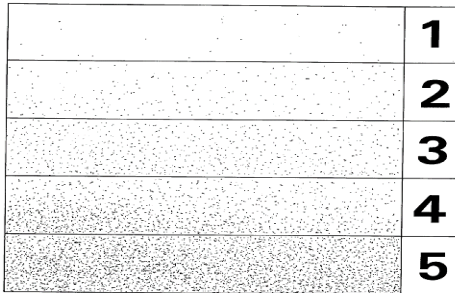
二、相关技术要求

除锈等级 **Sa 2.5 级** 表面粗糙度 **30-75 μ m** 漆膜厚度 **15±5 μ m**

喷砂室相对湿度高于 85%或钢材表面温度在露点上 3℃内时，不应进行喷砂处理。
85%的相对湿度限制表示喷砂室内部的湿度。

钢材表面处理后期及运用底漆之前，应按照油漆制造商要求，检查钢材表面清洁程度和外形。

冲砂前必须清除钢板表面油污，喷涂前清洁度为 I 级

冲砂等 级 Sa2.5		Sa2.5 非常彻底的喷射或抛射除锈：钢板表面会无可见的油脂、污垢，氧化皮、铁锈和油漆涂层等附着物，任何残留的痕迹应仅是点状或条纹状的轻微色斑。														
灰尘	<div><p>Figure 1 — Pictorial references corresponding to dust quantity ratings 1, 2, 3, 4 and 5</p><table><caption>Table 1 — Dust size classes</caption><tr><th>Class</th><th>Description of dust particles</th></tr><tr><td>0</td><td>Particles not visible under × 10 magnification</td></tr><tr><td>1</td><td>Particles visible under × 10 magnification but not with normal or corrected vision (usually particles less than 50 μm in diameter)</td></tr><tr><td>2</td><td>Particles just visible with normal or corrected vision (usually particles between 50 μm and 100 μm in diameter)</td></tr><tr><td>3</td><td>Particles clearly visible with normal or corrected vision (particles up to 0.5 mm in diameter)</td></tr><tr><td>4</td><td>Particles between 0.5 mm and 2.5 mm in diameter</td></tr><tr><td>5</td><td>Particles larger than 2.5 mm in diameter</td></tr></table></div>	Class	Description of dust particles	0	Particles not visible under × 10 magnification	1	Particles visible under × 10 magnification but not with normal or corrected vision (usually particles less than 50 μm in diameter)	2	Particles just visible with normal or corrected vision (usually particles between 50 μm and 100 μm in diameter)	3	Particles clearly visible with normal or corrected vision (particles up to 0.5 mm in diameter)	4	Particles between 0.5 mm and 2.5 mm in diameter	5	Particles larger than 2.5 mm in diameter	颗粒大小为“3”，“4”，“5”的灰尘分布量为1级。 若不用放大镜，在待涂表面可见的更小颗粒应去除。
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