ISO 2178:2016-03 (E)

Non-magnetic coatings on magnetic substrates - Measurement of coating thickness - Magnetic method

Contents

Page

Foreword v

1 Scope 1

2 Normative references 1

3 Termsanddefinitions 1

4 Principle of measurement 2
4.1 Basic principle of all magnetic measurement methods 2
4.2 Magnetic pull-off method 2
4.3 Magnetic inductive principle 3
4.4 Magnetic flux gauge 5

5 Factors affecting measurement accuracy 6
5.1 Basic influence of the coating thickness 6
5.2 Magnetic properties of the base metal 6
5.3 Electrical properties of the coating materials 7
5.4 Geometry: base metal thickness 7
5.5 Edge effect 7
5.6 Geometry: surface curvature 7
5.7 Surface roughness 8
5.8 Cleanliness: lift-off effect 8
5.9 Probe pressure 8
5.10 Probe tilt 8
5.11 Temperature effects 9
5.12 External electromagnetic fields 9

6 Calibration and adjustment of the instrument 9
6.1 General 9
6.2 Thickness reference standards 9
6.3 Methods of adjustment 10

7 Measurement procedure and evaluation 10
7.1 General 10
7.2 Number of measurements and evaluation 11

8 Uncertainty of the results 11
8.1 General remarks 11
8.2 Uncertainty of the calibration of the instrument 12
8.3 Stochastic errors 13
8.4 Uncertainties caused by factors summarized in Clause 5 13
8.5 Combined uncertainty, expanded uncertainty and final result 14

9 Precision 14
9.1 General 14
9.2 Repeatability (r) 14
9.3 Reproducibility limit (R) 15

10 Test report 15

Annex A (informative) Basic principle of all measurement methods 17

Annex B (informative) Basic performance requirements for coating thickness gauges which are based on the magnetic method described in this International Standard 19

Annex C (informative) Examples of experimental estimation of factors affecting the measurement . 21

Annex D (informative) Example of uncertainty estimation (see Clause 8) 26

Annex E (informative) Basics of the determination of the uncertainty of a measurement of the used measurement method corresponding to ISO/IEC Guide 98-3 29

Annex F (informative) Table of the student factor 31

Annex G (informative) Details on precision 32

Bibliography 37