

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 | Terms and definitions | 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 |