DIN EN ISO 2360:2017-12 (E)

Non-conductive coatings on non-magnetic electrically conductive base metals - Measurement of coating thickness - Amplitude-sen sitive eddy-current method (ISO 2360:2017)

Contents

Page

European foreword ... **3**

Foreword ... **4**

1 Scope ... **5**

2 Normative references ... **5**

3 Terms and definitions ... **5**

4 Principle of measurement ... **6**

5 Factors affecting measurement uncertainty ... **7**
5.1 Basic influence of the coating thickness ... 7
5.2 Electrical properties of the base metal ... 7
5.3 Geometry: Base metal thickness ... 8
5.4 Geometry: Edge effects ... 8
5.5 Geometry: Surface curvature ... 8
5.6 Surface roughness ... 8
5.7 Cleanliness: Lift-off effect ... 9
5.8 Probe pressure ... 9
5.9 Probe tilt ... 9
5.10 Temperature effects ... 9
5.11 Intermediate coatings ... 10
5.12 External electromagnetic fields ... 10

6 Calibration and adjustment of the instrument ... **10**
6.1 General ... 10
6.2 Thickness reference standards ... 10
6.3 Methods of adjustment ... 11

7 Measurement procedure and evaluation ... **12**
7.1 General ... 12
7.2 Number of measurements and evaluation ... 12

8 Uncertainty of the results ... **12**
8.1 General remarks ... 12
8.2 Uncertainty of the calibration of the instrument ... 13
8.3 Stochastic errors ... 14
8.4 Uncertainties caused by factors summarized in Clause 5 ... 14
8.5 Combined uncertainty, expanded uncertainty and final result ... 15

9 Precision ... **15**
9.1 General ... 15
9.2 Repeatability (r) ... 15
9.3 Reproducibility limit (R) ... 16

10 Test report ... **16**

Annex A (informative) **Eddy-current generation in a metallic conductor** **18**
Annex B (informative) **Basics of the determination of the uncertainty of a measurement of the used measurement method corresponding to ISO/IEC Guide 98-3** **22**
Annex C (informative) **Basic performance requirements for coating thickness gauges which are based on the amplitude-sensitive eddy-current method described in this document** **24**
Annex D (informative) **Examples for the experimental estimation of factors affecting the measurement accuracy** **26**
Annex E (informative) **Table of the student factor** **31**
Annex F (informative) **Example of uncertainty estimation (see Clause 8)** **32**
Annex G (informative) **Details on precision** **34**
Bibliography **38**