

**Oorganiska ytbeläggningar – Bestämning av
skiktjocklek – Terminologi och allmänna
riktlinjer (ISO 2064:1996)**

**Metallic and other inorganic coatings –
Definitions and conventions concerning the
measurement of thickness (ISO 2064:1996)**

ICS 25.220.40

Språk: engelska

Publicerad: april 2005

Europastandarden EN ISO 2064:2000 gäller som svensk standard. Detta dokument innehåller den officiella engelska versionen av EN ISO 2064:2000.

Denna standard ersätter SS-ISO 2064, utgåva 1 och SS-EN ISO 2064, utgåva 1.

The European Standard EN ISO 2064:2000 has the status of a Swedish Standard. This document contains the official English version of EN ISO 2064:2000.

This standard supersedes the Swedish Standards SS-ISO 2064, edition 1 and SS-EN ISO 2064, edition 1.

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EUROPEAN STANDARD
NORME EUROPÉENNE
EUROPÄISCHE NORM

EN ISO 2064

March 2000

ICS 25.220.30, 25.220.40

Supersedes EN ISO 2064:1994

English version

Metallic and other inorganic coatings - Definitions and conventions concerning the measurement of thickness (ISO 2064:1996)

Revêtements métalliques et autres revêtements inorganiques - Définitions et principes concernant le mesurage de l'épaisseur (ISO 2064:1996)

Metallische und andere anorganische Schichten - Definitionen und Festlegungen, die die Messung der Schichtdicke betreffen (ISO 2064:1996)

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EUROPEAN COMMITTEE FOR STANDARDIZATION
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Central Secretariat: rue de Stassart, 36 B-1050 Brussels

Foreword

The text of the International Standard from Technical Committee ISO/TC 107 "Metallic and other inorganic coatings" of the International Organization for Standardization (ISO) has been taken over as an European Standard by Technical Committee CEN/TC 262 "Metallic and other inorganic coatings", the secretariat of which is held by BSI.

This European Standard replaces EN ISO 2064:1994.

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of an identical text or by endorsement, at the latest by September 2000, and conflicting national standards shall be withdrawn at the latest by September 2000.

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

Endorsement notice

The text of the International Standard ISO 2064:1996 has been approved by CEN as a European Standard without any modification.

NOTE: Normative references to International Standards are listed in annex ZA (normative).

Introduction

An important requirement of most coating specifications is that the coating have a thickness not less than a given value (and in a few cases not greater than a given value). The method to be used for measuring the thickness of a particular coating is laid down in the coating specification.

The main purpose of this International Standard is to define exactly what is meant by the term “minimum thickness” when used in specifications for metallic and related coatings. In this context, the minimum thickness is defined as a local thickness over a small area.

With some methods, for example the microscopical method, ISO 1463, it is possible to detect appreciable variations in thickness across extremely small areas (for example pits or cracks) which might be considered as places where the specified minimum thickness has not been achieved. However, with other test methods (for example the coulometric method, ISO 2177:1985, *Metallic coatings — Measurement of coating thickness — Coulometric method by anodic dissolution*, or various non-destructive methods), such minute local variations in thickness cannot be detected. Therefore, the only practicable definition of minimum thickness is one that allows comparable results to be obtained by any of the approved test methods. Hence the minimum thickness should be a local thickness over an area that is as small as practicable, but not too small to accommodate any of the specified test methods. These areas are termed “reference areas” and are often large enough to accommodate a number of separate measurements by the chosen method. In order to obtain consistent results, especially with non-destructive tests, the mean of the measurements of such tests on the reference area should be taken as the local thickness.

In practice, it is usually permissible to test the coating at any place on the significant surface in order to find the minimum thickness on an article. Articles are usually tested at areas where the coating may be expected to be thinnest and so the definition of minimum thickness is the lowest value of local thickness (as defined in clause 3) found by the chosen method.

In the case of some coatings, such as hot-dipped and sprayed metal coatings, the coating specifications may call for compliance with a minimum local or an average thickness, or both. These may differ from the parameters defined in this International Standard and the relevant product specifications should be consulted.

Metallic and other inorganic coatings — Definitions and conventions concerning the measurement of thickness

1 Scope

This International Standard defines terms concerning the measurement of the thickness of metallic and other inorganic coatings on any substrate. In addition, it specifies some general rules to be followed in the measurement of minimum thicknesses of coatings.

2 Normative references

The following standard contains provisions which, through reference in this text, constitute provisions of this International Standard. At the time of publication, the editions indicated were valid. All standards are subject to revision, and parties to agreements based on this International Standard are encouraged to investigate the possibility of applying the most recent editions of the standard indicated below. Members of IEC and ISO maintain registers of currently valid International Standards.

ISO 1463:1982, *Metallic and oxide coating — Measurement of coating thickness — Microscopical method.*

3 Definitions

For the purposes of this International Standard, the following definitions apply.

3.1 significant surface: The part of the article covered or to be covered by the coating and for which the coating is essential for serviceability and/or appearance and where the coating must meet all of the specified requirements.

3.2 measuring area: The area of the significant surface over which a single measurement is made.

“Measuring area” for the following methods is defined as

- a) for analytical methods, the area over which the coating is removed;
- b) for the anodic dissolution method, the area enclosed by the sealing ring of the cell;
- c) for the microscopical method, the field of view at a specified magnification (see ISO 1463);
- d) for non-destructive methods, the probe area or the area influencing the reading (see also the Introduction).

3.3 reference area: The area within which a specified number of single measurements is required to be made.

3.4 local thickness: The mean of the thickness measurements, of which a specified number is made within a reference area (see also the Introduction).

3.5 minimum local thickness: The lowest value of the local thicknesses found on the significant surface of a single article (see also the Introduction).

3.6 maximum local thickness: The highest value of the local thicknesses found on the significant surface of a single article.

3.7 average thickness: Either the value obtained by analytical methods (see 5.1) or the mean of a specified number of local thickness measurements that are evenly distributed over the significant surface (see 5.2 and also the Introduction).

NOTE — In the case of components coated in bulk, the product specification may require determination of the value of the average thickness of a bath. In such cases the standard deviation must be known to be able to estimate the proportion of the batch that is below the thickness in question.