

Quick Start METRIC INSTRUCTIONS FOR USING **PRESS-O-FILM HT**

to measure the surface roughness of grit-blasted steel prior to painting

Primary units used in these instructions are micrometers (μm). Secondary units are thousandths of an inch (mils).

A: For measurement with **Coarse & X-Coarse** grades of tape, target roughness should be in the range 20 to 115 μm (0.8 to 4.5 mils).

B: To measure the tape you will need a gage specifically designed for use with replica tape. Pre-set the gage to **minus** 50 μm (**minus** 2.0 mils). On a standard Testex gage this is equivalent to pre-setting the gage to 150 μm (8.0 mils). Pre-setting has the effect of automatically subtracting the thickness of the incompressible layer.

C: Separate a piece of tape from its release paper and place on surface to be measured.

D: Firmly and completely compress replica film against the surface to be measured using an approved rubbing tool.

E: Measure thickness of resulting replica with gage.

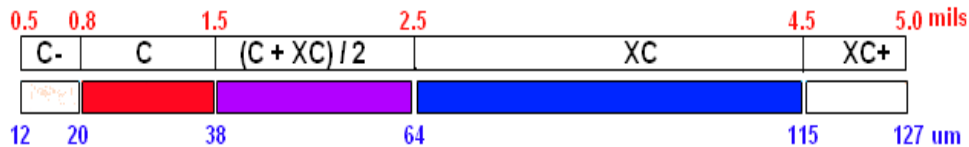
F: If a measurement made with either Coarse or X-Coarse grade tape is **between 38 and 64 μm (1.5 and 2.5 mils) inclusive**, take a 2nd measurement at the same spot with the OTHER grade.

If BOTH readings are in the above range, record the **average** of the two measurements as the (peak-to-valley) roughness.

If EITHER reading is outside this range **record it** as the profile.

Tape Range Illustration

Numbers in **blue** indicate roughness in micrometers (μm).
Numbers in **red** indicate roughness in mils (thousandths of an inch).



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