

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

The European Standard EN ISO 2064:2000 has the status of a  
British Standard

ICS 01.040.17; 17.040.20; 25.220.40; 25.220.99

## National foreword

This British Standard is the official English language version of EN ISO 2064:2000. It is identical with ISO 2064:1996. It supersedes BS EN ISO 2064:1995 which is withdrawn.

The UK participation in its preparation was entrusted to Technical Committee STI/37, Methods of test for metallic and related coatings, which has the responsibility to:

- aid enquirers to understand the text;
- present to the responsible international/European committee any enquiries on the interpretation, or proposals for change, and keep the UK interests informed;
- monitor related international and European developments and promulgate them in the UK.

A list of organizations represented on this committee can be obtained on request to its secretary.

### Cross-references

Attention is drawn to the fact that CEN and CENELEC Standards normally include an annex which lists normative references to international publications with their corresponding European publications. The British Standards which implement these international or European publications may be found in the BSI Standards Catalogue under the section entitled “International Standards Correspondence Index”, or by using the “Find” facility of the BSI Standards Electronic Catalogue.

A British Standard does not purport to include all the necessary provisions of a contract. Users of British Standards are responsible for their correct application.

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### Summary of pages

This document comprises a front cover, an inside front cover, the EN ISO title page, the EN ISO foreword page, the ISO title page, pages ii and iii, a blank page, pages 1 and 2, the annex ZA page and a back cover.

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This British Standard, having been prepared under the direction of the Sector Committee for Materials and Chemicals, was published under the authority of the Standards Committee and comes into effect on 15 July 2000

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ISBN 0 580 34331 6

### Amendments issued since publication

Amd. No.	Date	Comments

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)

This European Standard was approved by CEN on 24 January 2000.

CEN members are bound to comply with the CEN/GENELEC Internal Regulations which stipulate the conditions for giving this European Standard the status of a national standard without any alteration. Up-to-date lists and bibliographical references concerning such national standards may be obtained on application to the Central Secretariat or to any CEN member.

This European Standard exists in three official versions (English, French, German). A version in any other language made by translation under the responsibility of a CEN member into its own language and notified to the Central Secretariat has the same status as the official versions.

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EUROPEAN COMMITTEE FOR STANDARDIZATION  
COMITÉ EUROPÉEN DE NORMALISATION  
EUROPÄISCHES KOMITEE FÜR NORMUNG

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## 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).

# INTERNATIONAL STANDARD

**ISO**  
**2064**

Third edition  
1996-10-01

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

*Revêtements métalliques et autres revêtements inorganiques — Définitions et principes concernant le mesurage de l'épaisseur*



Reference number  
ISO 2064:1996(E)

## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

Draft International Standards adopted by the technical committees are circulated to the member bodies for voting. Publication as an International Standard requires approval by at least 75 % of the member bodies casting a vote.

International Standard ISO 2064 was prepared by Technical Committee ISO/TC 107, *Metallic and other inorganic coatings*, Subcommittee SC 2, *Methods of inspection and coordination of test methods*.

This third edition cancels and replaces the second edition (ISO 2064:1980), of which it constitutes a technical revision.

## 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.

## 4 Determination of local thickness

Average thickness measurements are usually made on small articles of limited total surface area.

### 4.1 Articles with significant surfaces less than 1 cm<sup>2</sup>

The normal reference area to be used for determining the local thickness shall be the whole of the significant surface of the article. The number of single measurements to be made within this reference area shall be agreed between the parties concerned. In special cases, however, smaller reference areas may be taken, but their sizes, number and location shall be agreed between the parties concerned.

### 4.2 Articles with significant surfaces greater than 1 cm<sup>2</sup>

The local thickness shall be determined within a reference area of approximately 1 cm<sup>2</sup> (where possible, a square of 1 cm side). Up to five distributed measurements may be made within this reference area (dependent upon the measuring method used) and the number to be made shall be agreed between the parties concerned.

### 4.3 Microscopical method

When using the microscopical method specified in ISO 1463, at least five distributed measurements shall be made along a length<sup>1)</sup> of a specified microsection.

## 5 Determination of average thickness

### 5.1 Analytical methods

When using mass-loss methods for determining average thickness, the selected measuring area shall be

large enough to provide a mass loss that can be determined with sufficient accuracy by the weighing method used.

If the area of the significant surface of the coated article is less than the required minimum measuring area, a number of individual articles shall be selected to provide the measuring area required for a single determination and the result shall be regarded as the average thickness.

If the area of the significant surface of the coated article does not greatly exceed the required minimum measuring area, a single determination on that article shall be regarded as the average thickness for the article. At least two articles shall be measured in order to verify the accuracy of the measurement.

If the area of the significant surface of the coated articles markedly exceeds the required minimum measuring area, a specified number of replicate determinations, distributed over the significant surface, shall be carried out and reported separately.

### 5.2 Other methods

If the area of the significant surface of the coated article does not greatly exceed the reference area for determining local thickness (see clause 4), the value of the local thickness shall be taken as the average thickness.

If the area of the significant surface of the coated article markedly exceeds the reference area for determining local thickness (see clause 4), the average thickness shall be taken as the mean of three to five local thickness determinations distributed over the significant surface.

1) For electroplated coatings this length may conveniently be 5 mm, but for coatings that tend to be more uniform in thickness, for example anodic oxide coatings, this length may be 20 mm.

**Annex ZA** (normative)  
**Normative references to international publications  
with their relevant European publications**

This European Standard incorporates by dated or undated reference, provisions from other publications. These normative references are cited at the appropriate places in the text and the publications are listed hereafter. For dated references, subsequent amendments to or revisions of any of these publications apply to this European Standard only when incorporated in it by amendment or revision. For undated references the latest edition of the publication referred to applies.

<u>Publication</u>	<u>Year</u>	<u>Title</u>	<u>EN</u>	<u>Year</u>
ISO 1463	1982	Metallic and oxide coatings - Measurement of coating thickness - Microscopical method	EN ISO 1463	1994

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