



® Management Procedure 2546  
Revision: A  
Date Issued: August 15, 2013  
Date Revised:

## Calibration Procedure

DeFelsko Corporation

PosiTector 6000 FLS

Coating Thickness Probe

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# 1 Introduction and UUC Performance Requirements

1.1 This procedure describes the calibration of DeFelsko Corporation PosiTector 6000 FLS probe with the following specification:

Table 1-1 Measurement Ranges

Probe	Measurement Range
6000 FLS	0 – 38 mm (0 - 1500 mils)

1.2 The unit being calibrated will be referred to as the UUC (Unit-Under-Calibration).

# 2 Measurement Standards and Support Equipment Performance Requirements

2.1 The UUC accuracy requirements are based upon the published UUC performance specifications.

2.2 The test uncertainty ratio applied in this Calibration Procedure is 4:1 unless otherwise stated.

2.3 The Minimum-Use-Specifications are the minimum test equipment specifications required to meet all the UUC accuracy requirements and the test uncertainty ratio applied.

Table 2-1 UUC Accuracy Requirements and Description

UUC	Performance Specifications		Test Method
6000 FLS	0 – 38 mm (0 - 1500 mils)	$\pm (0.2 \text{ mm} + 3\% \text{ of reading})$ $\pm (10 \text{ mils} + 3\% \text{ of reading})$	Compared to Reference Standards

Table 2-2 Minimum use specification

Range	Accuracy
0 – 38 mm (0 - 1500 mils)	$\pm 0.05 \text{ mm}$ ( $\pm 2.5 \text{ mils}$ )

Table 2-3 Actual Equipment Specification

Equipment Generic Name	Range	Accuracy	Manufacturer / Model #'s Applicable
Certified Polystyrene Blocks	12.7 – 19 mm (500 - 750 mils)	$\pm (0.0025 \text{ mm} + 0.05\% \text{ of thickness})$ $\pm (0.1 \text{ mil} + 0.05\% \text{ of thickness})$	DeFelsko Corporation, STD-P8

**Caution:** The instructions in this Calibration Procedure relate specifically to the equipment and conditions listed in Section 2. If other equipment is substituted, the information and instructions must be interpreted accordingly.

Table 2-4 Calibration Environmental and Warm-Up Requirements

Measurement Standards & Support Equipment Environmental Requirements:	Temperature: $23 \pm 5^{\circ}$ C. Relative Humidity: Less than 95%
Measurement Standards & Support Equipment Warm-up and Stabilization Requirements:	Not Required

### 3 Preliminary Operations

**Note:** Review the entire document before starting the calibration process.

3.1 Visually inspect the measurement face of the probe for signs of damage or excessive wear, this could impact probe accuracy.

#### 3.2 Gage Reset

3.2.1 When the unit is powered down, simultaneously hold the “+” and middle buttons until the reset symbol (2 arrows) appears.

**Caution:** Be sure to hold the probe in the air and well away from any metal surface during the RESET process.

#### 3.3 Probe Zero Calibration Adjustment

3.3.1 While holding the probe in the air, select the Cal Settings “Zero” function and then indicate the number of readings (1) to be used.

3.3.2 Measure the middle of a flat uncoated (zero) 1018 steel plate at least 10” x 10” x 0.2”.

3.3.3 Re-measure the zero plate. If the reading is within +/-0.2 mm (10 mil) continue, otherwise repeat steps 3.3.1 and 3.3.2.

#### 3.4 Material Adjustment

3.4.1 From the Settings menu select 2 pt adjust.

3.4.2 Place the 12.7 mm (500 mil) polystyrene block in the center of the same uncoated plate used to zero the probe and take a reading. Adjust the displayed value to the value of the block. Note: The gage adjusts in 0.2 mm or 10 mil increments.

3.4.3 Stack two more 12.7 mm (500 mil) blocks onto the existing block 12.7 mm block for a total thickness of 38.1 mm (1500 mil). Take a reading and adjust the displayed value to the total value of the 3 blocks.

## 4 Calibration Process

**Note:** Whenever the test requirement is not met, verify the results of each test and take corrective action before proceeding.

### 4.1 Review the Performance Requirements Table 5-1.

**Note:** The probe calibration may be verified in either normal or high-resolution mode. Accuracy is the same for both modes.

### 4.2 Using the appropriate Certificate of Calibration template for the UUC, record the thickness from the Reference Standards.

### 4.3 Determine the allowed range of readings for the UUC using the calculation methods shown in Table 5-1.

### 4.4 Stack the appropriate blocks, in the center of the same uncoated plate used to zero the probe, to take readings at the following thicknesses: 12.7 mm (500 mil), 19 mm (750 mil), 31.8 mm (1250 mil) and 38.1 mm (1500 mil). Verify that the readings are within the allowable limits determined in section 4.3. Record the readings on the Certificate of Calibration.

**Note:** Record all digits displayed on the LCD. This may vary depending on the resolution mode. In taking readings the probe shall be centered on the Reference Standards.

## 5 Performance Requirements

**Note:** The technician will collect the data needed to complete columns A and B of the appropriate table below. Do not write in this procedure.

Table 5-1 Performance Requirements and Calibration Data for PosiTector 6000 FLS

Thickness on Reference Standard Label (mm)	Min. Reading Allowed <sup>①</sup> (mm)	Max. Reading Allowed <sup>②</sup> (mm)	Actual Probe Measurement (mm)
A			B

① Calculation (A times 0.97) – 0.2. Round up to the nearest even 0.02 mm increment

② Calculation (A times 1.03) + 0.2. Round down to the nearest even 0.02 mm increment.

\*For imperial/metric readings convert using 1 mil = 0.0254 mm

# Management Procedure Change Notice

Procedure Number: MP 2546

Revision Level: A

Date of Change: August 15, 2013

Title: Calibration Procedure for PosiTector 6000 FLS

Reason for Change: <ul style="list-style-type: none"><li>• New product</li></ul>
Description of Change: <ul style="list-style-type: none"><li>• New procedure</li></ul>

I confirm I have read and understand the procedure and the change described above.

Printed Name	Signature	Date

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