



Management Procedure 2534
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Calibration Procedure

DeFelsko Corporation

DeFelsko/PosiTector 6000 FHS

Coating Thickness Gage

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1 Introduction and UUC Performance Requirements

1.1 This procedure describes the calibration of DeFelsko Coating Thickness Gage, DeFelsko/PosiTector 6000 FHS with the following specifications:

Table 1-1 Measurement Ranges

Gage	Measurement Range
6000 FHS	0-20 mm and 0-750 mils

1.2 The unit being calibrated will be referred to as the UUC (unit-under-calibration).

1.3 UUC Environmental Range:

- Temperature: $23 \pm 5^\circ \text{C}$.
- Relative Humidity: Up to 95%

1.4 UUC Warm-up and Stabilization Period requirements: Does not apply.

Table 1-2 UUC Calibration Requirements and Calibration Description

Unit-Under-Test (UUC) Parameter or Function		Performance Specifications	Test Method
1.1	Accuracy Test 6000 FHS	0 to 6 mm, $\pm (0.02 \text{ mm} + 1\% \text{ of reading})$ > 6 mm, $\pm (0.02 \text{ mm} + 5\% \text{ of reading})$ 0 to 250 mils, $\pm (1 \text{ mil} \pm 1\% \text{ of reading})$ > 250 mils, $\pm (1 \text{ mil} \pm 5\% \text{ of reading})$	Compared to Coating Thickness Reference Standards.

2 Measurement Standards and Support Equipment Performance Requirements

2.1 Minimum-Use-Specifications are the calculated minimum performance specifications required for the measurement standards and support equipment to be utilized for comparison measurements required in the Calibration Process.

2.2 The Minimum-Use-Specifications are developed through uncertainty analysis and are calculated through assignment of a defined and documented uncertainty ratio or margin between the specified tolerances of the UUC and the capabilities (uncertainty specifications) required of the measurement standards system.

2.3 The uncertainty ratios applied in this Calibration Procedure are 4:1 or better.

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.

Measurement Standards & Support Equipment Environmental Requirements: Temperature: $23 \pm 5^\circ \text{C}$.
Relative Humidity: Less than 95%

Measurement Standards & Support Equipment Warm-up and Stabilization Requirements: Not Required

Table 2-1 Measurement Standards & Support Equipment Performance Requirements

Equipment Generic Name (Quantity)	Minimum-Use-Specifications		Manufacturer/Model #'s Applicable
	Range	Accuracy	
2.1 Thickness Reference Standards	0 – 20 mm	$\pm (2.54 \mu\text{m} + .05\% \text{ of standard})$	DeFelsko Corporation, Thickness Calibration Standards, Model CAL-P2
	0 - 750 mils	$\pm (0.1 \text{ mil} + .05\% \text{ of standard})$	

3 Preliminary Operations

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

3.1 Visual Inspection

3.1.1 Visually inspect the UUC for:

- Damaged LCD readout
- probe wear or coating
- cracked or broken case
- missing probe cover, battery door or other parts
- proper identification

3.1.2 Damage or excess wear should be repaired prior to beginning the calibration process.

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 Perform the Main Menu Reset function.

Caution: Be sure to keep the probe well away from any metal surface during the RESET process.

4.2 Perform a 2-Pt Calibration Adjustment using measurement standards above and below the range of standards to be used for calibration. 2-Pt Calibration instructions are detailed in the instruction manual.

4.3 Accuracy Test

4.3.1 Review the Performance Requirements Table 5-1.

Note: DeFelsko/PosiTector 6000 gages with serial numbers greater than 40000 have a high-resolution mode. The gage may be calibrated in either normal or high-resolution mode. Accuracy is the same for both modes. Verify the mode in which the customer wants the gage calibrated prior to beginning the actual calibration.

4.3.2 Using the appropriate Certificate of Calibration template for the UUC, record the reference material values on the form.

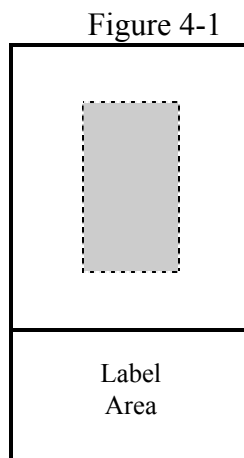
4.2.3 Determine the allowed range of readings using the calculation methods shown in columns D and E of Table 5-1.

4.2.4 Place the Thickness Reference Standard on a large (at least 4”x 4”) uncoated steel plate to make measurements.

4.2.5 Use the UUC to make readings of each standard. Verify that the readings are within the allowable limits determined in 4.2.3. Record the reference standard values and the readings on the Certificate of Calibration.

Note: Record all digits displayed on the LCD. This may vary depending on the resolution mode.

4.2.6 In taking readings the probe should be centered on the Coating Thickness Reference Standard as shown in the shaded area (see Figure 4-1).



5 Performance Requirements

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

Table 5-1 Performance Requirements and Calibration Data for DeFelsko/PosiTector 6000 FHS

Nominal Thickness	Reference Standard	UUC Indication or Reading *		
		Gage Measurement	Min. Reading Allowed	Max. Reading Allowed
A	B	C	D	E
0 mils	Uncoated	0 mils	minus 1 mil	plus 1 mil
100 mils			0.99 times B minus 1 mil	1.01 times B plus 1 mils
250 mils			0.95 times B minus 1 mil	1.05 times B plus 1 mil
500 mils				
750 mils				

* For metric readings convert using 1 mil = 25.4 microns