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).

<table>
<thead>
<tr>
<th>0.5</th>
<th>0.8</th>
<th>1.5</th>
<th>2.5</th>
<th>4.5</th>
<th>5.0 mils</th>
</tr>
</thead>
<tbody>
<tr>
<td>C</td>
<td>C</td>
<td>(C + XC) / 2</td>
<td>XC</td>
<td>XC+</td>
<td></td>
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</tbody>
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C- 0.5, 0.8, 1.5, 2.5, 4.5, 5.0 mils
C+ 12, 20, 38, 64, 115, 127 μm

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