

Quick Start
INCH INSTRUCTIONS FOR
USING
PRESS-O-FILM HT

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

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

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

B: To measure the tape you will need a gage specifically designed for use with replica tape. Pre-set the gage to minus 2.0 mils (minus 50 µm). On a standard Testex gage this is equivalent to pre-setting the gage to 8.0 mils (150 µm). 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 1.5 and 2.5 mils (38 and 64 µm) 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 **red** indicate roughness in mils (thousandths of an inch).
 Numbers in **blue** indicate roughness in micrometers (µm).

