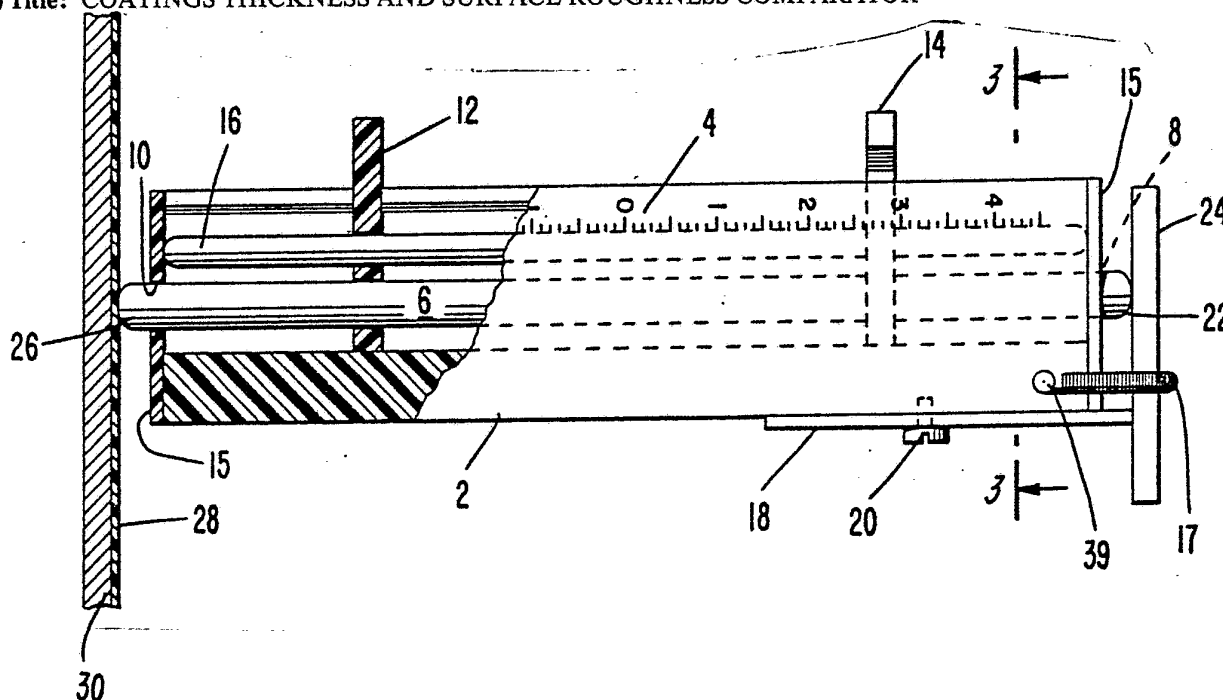




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(54) Title: COATINGS THICKNESS AND SURFACE ROUGHNESS COMPARATOR



(57) Abstract

A coating thickness and surface comparator for measuring the thickness of nonmagnetic coatings (28) or roughness on ferromagnetic base materials. A permanent rod magnet (6) and a ferromagnetic rod (16) are supported by nonmagnetic slides (12, 14) parallel to one another. When a standard base (24) is placed at one end (22) of the rod magnet (6) and a coated or roughened base (30) is placed at the other end, the slides (12, 14) are pushed together toward the middle of the rod magnet (6). The coincidence of the slides (12, 14) varies from the middle of the bar magnet (6) in proportion to coating thickness (28) or roughness.

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-1-

COATING THICKNESS AND SURFACE ROUGHNESS COMPARATORTechnical Field

The field of the invention is electricity, measuring and testing wherein a layer or layered material thickness is measured using a magnetic field to test the material. The present invention is particularly concerned with the measurement of the thickness of nonmagnetic coatings or layers on magnetic base materials.

Background Art

The state of the art of measuring the thickness of nonmagnetic coatings on a magnetic base using a magnetic field may be ascertained by reference to U.S. Patents 2,469,476; 2,625,585; 2,903,645; 3,521,160 and 3,699,487, the disclosures of which are incorporated herein by reference.

U.S. Patent 2,469,476 of Sellers discloses an instrument for measuring the thickness of nonmagnetic coatings on a ferrous base and the patent also discloses that it is possible to use the instrument for measuring the irregularities in the surface of a machined ferrous material. According to this patent an adjustable bar magnet bridge is pivoted between the legs of a U-shaped magnet. The limbs of the U-shaped magnet are placed on the surface to be measured. The pivoted bar magnet has an indicator attached thereto and is spring biased so that changes in the magnetic flux of the U-shaped magnet indicate the layer thickness or roughness.

The magnetic measuring gauge disclosed in U. S. Patent 2,625,585 makes use of the principle that



-2-

forces necessary to disengage a magnet from a workpiece vary in inverse proportion to the thickness of the non-magnetic plating or coating disposed upon the magnetic base surface. U.S. Patent 2,903,645 makes use of this same principle but in a more complex instrument.

5 U.S. Patent 3,521,160 is representative of a series of patents of Nix et al which show magnetic thickness gauges using a magnet mounted on the end of a balanced rotatable arm to which a dial is coupled over a spring. The dial is turned until the increasing
10 tension of the spring breaks the magnetic contact and the thickness is read directly from the dial.

Steingroever discloses in U.S. Patent 3,699,487 magnets of anisotropic materials for use in the magnetic thickness gauges.

15 According to these magnetic thickness gauges of the prior art, the magnet is placed on a coated steel surface and pulled off by a spring. The force required to pull the spring off of the surface is indicated on a scale and expressed in coating thickness.
20 The spring force and the magnetic force are of an uncomplimentary nature and produce a logarithmic scale. As time goes on, the magnet either loses or gains magnetism and the spring is subject to fatigue and temperature variations. To obtain a fair degree of
25 accuracy, each prior art gauge has to be individually calibrated and requires an elaborate set-up which is very time consuming. These so-called "pull-off gauges" are calibrated to a mild steel plate. As soon as the coated steel surface is of a rough nature or the
30 substrate is of a different steel than that to which the gauge is calibrated, the readings of these gauges become relative.



-3-

Objects and Brief Disclosure of Invention

Having in mind the limitations of the prior art, it is an object of the present invention to provide a coating thickness and surface roughness comparator which avoids the uncomplimentary reaction between magnetic force and spring force..

This object is accomplished in the present invention by using the principle of magnetic force versus friction.

In a particular embodiment of the comparator of the present invention, the comparator has the following elements:

- (a) a permanent rod magnet or a rod having equal magnets at each end;
- (b) a ferromagnetic rod approximately parallel to the permanent rod magnet or the rod having equal magnets at each end;
- (c) nonmagnetic slides or spacers preventing contact between the rod magnet and the ferromagnetic rod; and
- (d) an indicator of the middle of the rod magnet.

The comparator is used for making measurements by placing a first or reference pole of the rod magnet in contact with a reference ferromagnetic base material. The second or measuring pole of the rod magnet is placed in contact with the coated or roughened ferromagnetic surface to be measured. Both slides or spacers are moved to the extremities of the measuring and reference poles, respectively, and then moved together by hand or other means. An indication of the center or middle position of the rod magnet is provided and deviations from this center point by the coincidence of the slides is an indication of the



-4-

thickness and/or roughness of the surface being measured.

Description of the Drawings

5 The invention is further explained by reference to the accompanying drawings showing the preferred embodiment of the present invention, wherein:

10 Fig. 1 is a side view in partial cross-section of the coating thickness and surface roughness comparator of the present invention as used with a reference surface and a coated surface;

Fig. 2 is a bottom plan view of Fig. 1; and

Fig. 3 is a cross-sectional view of Fig. 1 along the line III-III.

15 Detailed Description of the Best Mode for Carrying Out the Invention and of the Preferred Embodiment

20 With particular reference to Fig. 1, the comparator is shown having a housing or casing 2 with a scale 4 thereon. The scale 4 is calibrated with a plus scale on one side of the center or middle of the permanent rod magnet 6 and a minus scale on the other side of the middle of the rod magnet.

25 The rod magnet 6 is supported in holes 8,10 at the ends of the housing. The housing 2 is composed of a nonmagnetic material and the holes 8,10 can hold the rod magnet 6 securely by friction so that the middle of the rod magnet is in register with the zero indication of the scale 4.

30 Nonmagnetic slides or spacers 12, 14 support a ferromagnetic rod 16 substantially parallel to the rod 6. The ferromagnetic rod 16 is preferably a cold



-5-

rolled steel rod. The ends 15 of the housing 2 prevent a horizontal movement of the ferromagnetic rod 16.

An adjustable spacer 18 is releasably fixed to the housing 2 by a screw 20. An uncoated steel plate 24 is positioned adjacent a reference pole 22 (one end of the rod 6) and a measuring pole 26 (the other end of the rod 6) is placed against a coating 28 on a steel plate 30. The spacer 18 is provided with a V-notch on one end and is adjustable so as to accommodate a rod (not shown) rather than the plate 24 if desired. During operation of the device (either calibration or normal use) the uncoated steel plate 24 (or a rod) is releasably fixed at the end of the device by an elastic member or spring 17. The spring 17 passes over two arms 39 which extend from either side of the housing 2. The arms 39 are provided with grooves so as to securely receive the ends of the spring 17. In this way, the plate 24 is releasably urged against the end of the rod magnet 6 and the end of the adjustable spacer 18.

The nonmagnetic materials: the housing 2, the spacers 12 and 14, the adjustable spacer 18 and the screw 20, are suitably made of unplasticized plastics such as Nylon 6-6 or copper base metals such as brass.

In Fig. 2, the adjustable spacer 18 is shown with an adjustment slot 19 so as to permit the spacer 18 to be moved relative to the housing when the plate 24 is replaced by a rod (not shown).

The slider 14 is shown in Fig. 3 with two notches 32, 34 engaging a longitudinal opening 36 of the housing 2 and also supporting the rods 16 and 6 in the holes 38 and 40, respectively.

A method of using the present invention is discussed with reference to Fig. 1. To measure the



-6-

thickness of the nonmagnetic coating 28 on the base 30, the measuring pole 26 is placed adjacent to the coating. The measuring pole 26 is preferably arranged perpendicularly relative to the coating to be measured. Likewise, the reference pole 22 is preferably arranged perpendicular to the standard plate 24. Both the base 30 and the standard plate 24 are preferably of the same ferromagnetic material, namely steel, and preferably are of the same thickness or roughness.

If desired, the base 30 (and the coating to be measured) may also be arranged either horizontally or vertically with the measuring pole 26 arranged at an angle of 45° relative to the base 30. In this way, any effect of gravity on the accuracy of the device is minimized by maintaining the device at an angle of 45° to the horizon.

If the device is to be oriented at an angle of 45° with respect to the coating to be measured, the rod 6 preferably extends sufficiently beyond the ends of the housing so that the device may be readily oriented at the angle of 45° with the end of the rod 6 in contact with the coating to be measured.

Whether the device is horizontal, vertical or at an angle of 45° , the sliders 12 and 14 are moved outwardly toward the measuring pole 26 and the reference pole 22, respectively, and the sliders are then pushed together until they coincide.

Due to the coating 28, the measuring pole is not attracted to the base 30 to the same extent as the reference pole 22 is attracted to the standard plate 24. This magnetic attraction of the pole 26 to the base 30 varies inversely according to the thickness of the coating 28 and as a result of the reduced magnetic



-7-

attraction, the rod 16 is attracted more strongly at the measuring pole 26.

As a result of this increased magnetic attraction between the measuring pole 26 and the rod 16, more force is applied to the slider 12 so that when the slider 12 is moved to the right to coincide with the slider 14, increased friction is applied. As a result of the increased friction between the slider 12 and the rods 6 and 16, the slider 12 drags and will be positioned to the left of the zero reading of the scale 4 when the two sliders 12, 14 meet. The reading on the scale 4 is an indication of the thickness of the coating 28.

The device according to the present invention may also be operated in other manners. For example, the standard plate 24 may be replaced by a standard plate having a known coating thickness and as a result thicker coatings can be measured at the measuring pole 26 without exceeding the range of the scale 4.

In yet another method of operation, the reference pole 22 is first placed preferably at an angle of 45° to the horizon and contacts a standard plate (not shown) which is arranged either horizontally or vertically. There is no plate provided at the measuring pole 26.

Again the sliders 12 and 14 are moved to the measuring pole 26 and to the reference pole 22, respectively, and they are then pushed together until they coincide and a first reading to the left of zero on scale 4 is recorded.

Now the reference pole 22 is placed adjacent to and preferably at an angle of 45° with respect to the base 30 having a nonmagnetic coating 28 and again there is no plate at the measuring pole 26.



-8-

The sliders 12 and 14 are moved to the measuring pole 26 and to the reference pole 22, respectively, and they are then pushed together until they coincide and a second reading to the left of zero on the scale 4 is recorded.

The difference between the first reading recorded and the second reading is representative of the thickness of the coating 28.

The principles, preferred embodiments and modes of operation of the present invention have been described in the foregoing specification. The invention which is intended to be protected herein should not be construed as limited to the particular forms disclosed, since these are to be regarded as illustrative rather than restrictive. Variations and changes may be made by those skilled in the art without departing from the spirit of the present invention.



-9-

WHAT IS CLAIMED IS:

1. A coating thickness comparator comprising:

(a) a permanent rod magnet having a middle, a reference pole and a measuring pole;

(b) a ferromagnetic rod arranged parallel to said permanent rod magnet;

(c) at least two nonmagnetic slides supporting said permanent rod magnet and said ferromagnetic rod and maintaining said rods substantially parallel to one another; and

(d) housing means indicating said middle whereby one of said poles extends beyond one end of said housing, said housing means having indicating means for representing said coating thickness to be measured.

2. The thickness comparator of claim 1, wherein said slides are suspended in a nonmagnetic housing and said indicating means comprises a scale provided on said housing parallel to said rods.

3. The thickness comparator of claim 2, further comprising an adjustable spacer on said housing releasably mounted adjacent said reference pole.

4. The thickness comparator of claim 3, wherein said housing, slides, and adjustable spacer are made of plastic.

5. The thickness comparator of claim 1, wherein both of said poles extend beyond the ends of said housing.



-10-

6. The thickness comparator of claim 1 further comprising a reference plate releasably mounted adjacent said reference pole.

5 7. The thickness comparator of claim 1 wherein said one of said poles extends sufficiently beyond said one end of said housing whereby said thickness comparator may be oriented at 45° to said coating thickness to be measured.



1/1

Fig. 1

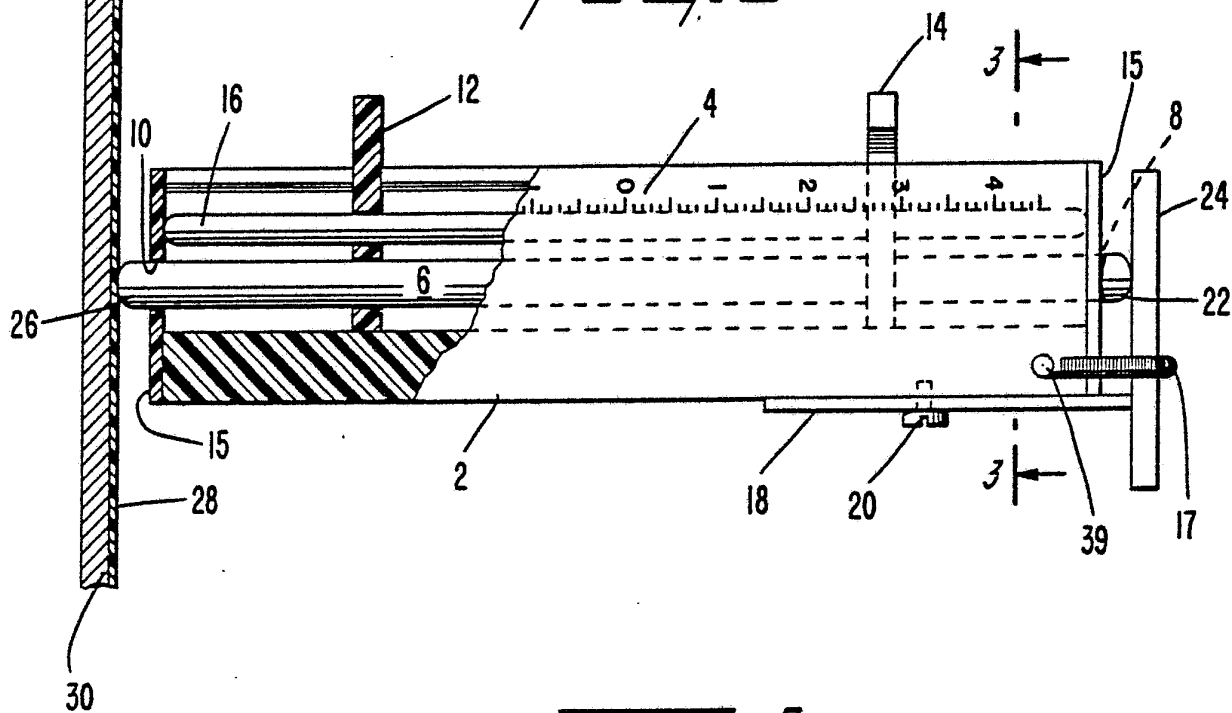


Fig. 2

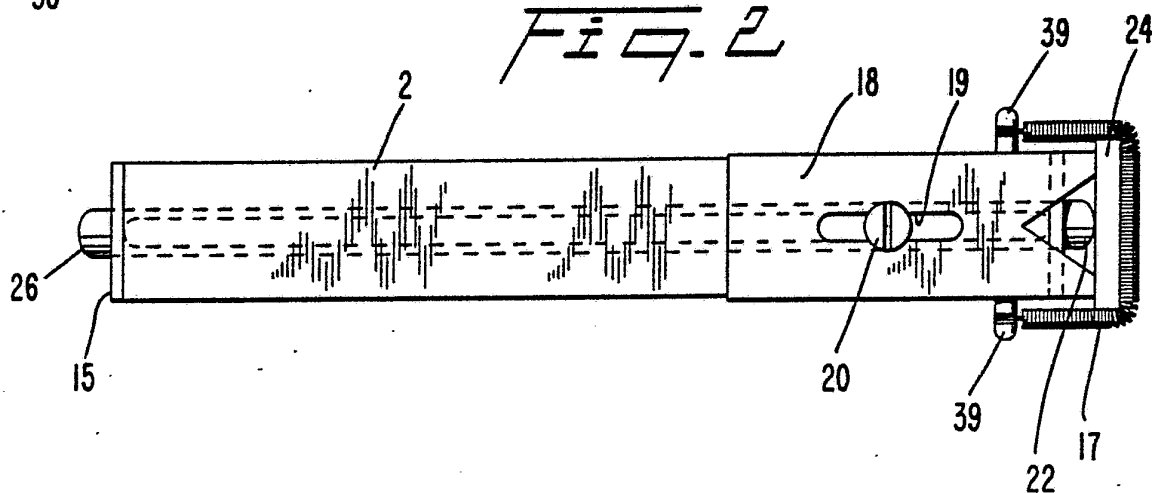
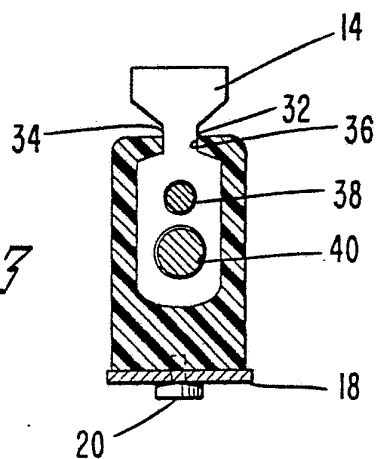


Fig. 3



INTERNATIONAL SEARCH REPORT

International Application No PCT/US82/01602

I. CLASSIFICATION OF SUBJECT MATTER (if several classification symbols apply, indicate all) ³ According to International Patent Classification (IPC) or to both National Classification and IPC INT. CL. ³ G01B 7/10; G01R 33/12 US CL. 324/230																				
II. FIELDS SEARCHED Minimum Documentation Searched ⁴ <table style="width: 100%; border: none;"> <tr> <td style="width: 25%; border: none;">Classification System</td> <td style="border: none;">Classification Symbols</td> </tr> <tr> <td style="border: none; text-align: center; vertical-align: middle;">US</td> <td style="border: none;">324/207, 229-231; 33/169F</td> </tr> </table> Documentation Searched other than Minimum Documentation to the Extent that such Documents are Included in the Fields Searched ⁵			Classification System	Classification Symbols	US	324/207, 229-231; 33/169F														
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III. DOCUMENTS CONSIDERED TO BE RELEVANT ¹⁴ <table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th style="width: 10%;">Category ⁶</th> <th style="width: 60%;">Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷</th> <th style="width: 30%;">Relevant to Claim No. ¹⁸</th> </tr> </thead> <tbody> <tr> <td style="text-align: center;">A</td> <td>US, A 2507529 Published 16 May 1950, (LIPSON)</td> <td></td> </tr> <tr> <td style="text-align: center;">A</td> <td>US, A 2749505 Published 05 June 1956 (McNary)</td> <td></td> </tr> <tr> <td style="text-align: center;">A</td> <td>US, A 3761804 Published 25 Sept. 1973 (STEINGROEVER)</td> <td></td> </tr> <tr> <td style="text-align: center;">A</td> <td>GB, A 575150 Published 05 Feb. 1946 (SPENCER-TIMMS)</td> <td></td> </tr> <tr> <td style="text-align: center;">A</td> <td>GB, A 1436559 Published 19 May 1976 (CRAWFORD)</td> <td></td> </tr> </tbody> </table>			Category ⁶	Citation of Document, ¹⁶ with indication, where appropriate, of the relevant passages ¹⁷	Relevant to Claim No. ¹⁸	A	US, A 2507529 Published 16 May 1950, (LIPSON)		A	US, A 2749505 Published 05 June 1956 (McNary)		A	US, A 3761804 Published 25 Sept. 1973 (STEINGROEVER)		A	GB, A 575150 Published 05 Feb. 1946 (SPENCER-TIMMS)		A	GB, A 1436559 Published 19 May 1976 (CRAWFORD)	
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* Special categories of cited documents: ¹⁵ "A" document defining the general state of the art which is not considered to be of particular relevance "E" earlier document but published on or after the international filing date "L" document which may throw doubts on priority claim(s) or which is cited to establish the publication date of another citation or other special reason (as specified) "O" document referring to an oral disclosure, use, exhibition or other means "P" document published prior to the international filing date but later than the priority date claimed "T" later document published after the international filing date or priority date and not in conflict with the application but cited to understand the principle or theory underlying the invention "X" document of particular relevance; the claimed invention cannot be considered novel or cannot be considered to involve an inventive step "Y" document of particular relevance; the claimed invention cannot be considered to involve an inventive step when the document is combined with one or more other such documents, such combination being obvious to a person skilled in the art. "&" document member of the same patent family																				
IV. CERTIFICATION <table style="width: 100%; border: none;"> <tr> <td style="width: 50%; border: none;"> Date of the Actual Completion of the International Search ² 17 February 1983 </td> <td style="width: 50%; border: none;"> Date of Mailing of this International Search Report ² 24 FEB 1983 </td> </tr> <tr> <td style="border: none;"> International Searching Authority ¹ ISA/US </td> <td style="border: none;"> Signature of Authorized Officer ²⁰ Gerard R. Strecker </td> </tr> </table>			Date of the Actual Completion of the International Search ² 17 February 1983	Date of Mailing of this International Search Report ² 24 FEB 1983	International Searching Authority ¹ ISA/US	Signature of Authorized Officer ²⁰ Gerard R. Strecker														
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