

# 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 ( $\mu\text{m}$ ).

**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  $\mu\text{m}$ ).

**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  $\mu\text{m}$ ). On a standard Testex gage this is equivalent to pre-setting the gage to 8.0 mils (150  $\mu\text{m}$ ). 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.

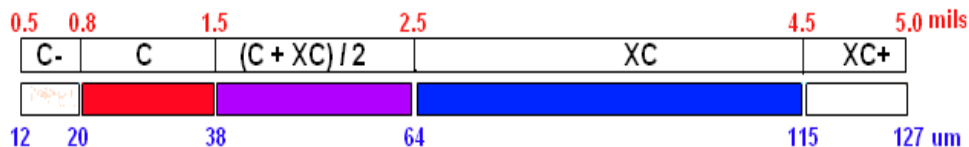
**F:** If a measurement made with either Coarse or X-Coarse grade tape is **between 1.5 and 2.5 mils (38 and 64  $\mu\text{m}$ ) inclusive**, take a 2<sup>nd</sup> measurement at the same spot with the OTHER grade.

**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 ( $\mu\text{m}$ ).



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