



**ELECTROMAGNETIC PROBE FOR MEASURING THE
THICKNESS OF THIN COATINGS ON MAGNETIC
SUBSTANCES.**

The present invention relates to an electromagnetic measuring probe of the kind comprising at least one pole-piece composed of a magnetic material of high magnetic permeability having a pole-piece front face, a
5 recess machined into the pole-piece front face extending into the body of the pole-piece, a pin composed of another material positioned within the recess, and a spherical segment contact surface.

An electromagnetic measuring probe of this type has
10 been described in German Patent Disclosure No. 25 56 340.

German Utility Patent 72 43 915 as well as German Utility Patent 73 36 864 also describe such an apparatus.

15 The said electromagnetic measuring probe allows the thickness of non-magnetic coatings or platings on magnetic substrate materials to be measured, for instance, a coat of paint on an iron or steel part..

All these measuring probes have an exciter winding
20 which is connected to a constant alternating-current supply. Furthermore, there is an induction winding

which generates a voltage U . The voltage in the induction winding is a measure of the thickness of the non-magnetic coating or plating. This type of thickness measurement for thin coating or platings should at least provide linearity of readout, i.e. a pointer should, for example, deflect twice as far for a coating or plating of double a certain thickness than it does for the said thickness alone. It is highly desirable that thin coating be measured without any influence from the substrate material on the characteristic curve. In this case, thin coatings are considered to be those which generate voltages lying within 0 to $1/3$ of the normalized voltage, as defined later in the text.

15 It is of course a well known fact that the relationships between the generated voltage and the coating thickness are not linear for thin coatings or platings. It is, however, exactly in this range where linear measurements are most desirable. From the practical point of view, however, the range from 0 to 20 roughly speaking 50 micrometers is interesting as a lower range for coating and plating thicknesses.

Obviously, all this instruments must have facilities for switching ranges. If, for example, 25 thicknesses up to 1000 micrometers are to be measured,

and the said thickness is chosen as the upper end-scale value, then a thickness of 10 micrometers will be practically impossible to read.

Since it is impossible to avoid switching measuring 5 ranges, then it is highly desirable that the said voltage is a linear function of coating or plating thickness not only at the lower end of the range but also retains this same linearity to the highest possible thickness values, thus avoiding the necessity 10 of using a different linear function in the upper ranges.

It must also be possible, of course, to make linear measurements in the lower range from 0 to 50 micrometers even when the probe is not handled with any 15 particular care.

The conditions of measurement may change neither during a demonstration at a trade fair, nor over the long term in a harsh industrial environment. In the lower range in particular, the geometry of the ~~crowned~~ 20 contact surface is an important factor. In accordance with Germany Utility Patent 73 36 864 an attempt was made to make the ~~crowned~~ contact surface wear-resistant by depositing a titanium carbide coating onto it, i.e., to contrive that the geometry did not change.

The coating, however, is very hard. It is deposited on a relatively soft material. If the thickness of the coating lies between 3 and 15 micrometers, it is possible that the titanium carbide coating will rupture when the probe is set down hard, because the substrate material underneath deforms. It is also not very easy to deposit a uniformly thick coating on the substrate. If the coating is not uniformly thick, then different measured values are obtained depending on whether the probe is set down exactly at the centre of the ~~crowned~~ contact surface or at another position. This realistic numerical example illustrates another problem associated with the measurement of thin coatings which, as yet, has no completely satisfactory solution.

15 A third problem must also be considered: The same probe must also be able to measure coatings on both flat surfaces and curved surfaces of small radius of curvature. An example of the latter is e.g., a small nail, a small spring or similar. An object of the invention is to ^{provide} ~~indicate~~ a measuring probe of the type specified in the introduction, which allows linear measurements to be made, particularly in the range of thin coatings, while at the same time avoiding non-linearity problems which stem from the magnetization curve as well as the geometry of the crowned contact surface. This object is also to be fulfilled for the

measurement of small parts.

According to the invention there is provided an electromagnetic measuring probe comprising at least one pole-piece composed of a magnetic material of high magnetic permeability, said pole-piece having a pole-piece front face, a recess machined into the pole-piece front face extending into the body of the pole-piece, and a pin composed of another material positioned within the recess, wherein the pin is composed of hard metal which has a low magnetic permeability in ~~the external face of the pin~~ comparison to the material of the pole-piece, and the external face of the pin comprises a spherical segment contact surface for contacting a layer to be measured.

Surprisingly enough, the said configuration brings with it not only the aforementioned linearisation. It also has the result that the characteristic curves for the very hard-magnetic and very soft-magnetic materials are practically identical. For example, the characteristic curve for hardened steel is practically the same as that for soft iron over the entire measuring range. The pin may be circular cylindrical to allow a more uniform magnetic flux density. Moreover commercially available pins designed for other purposes can be used. Finally, despite the close tolerances of the pin, it can be manufactured inexpensively. The pole-piece may be circular

cylindrical to allow not only the pole piece to be inexpensively manufactured to very close tolerances, but also allow the recess to be precisely machined at the correct coaxial position. The pin is preferably
5 composed of sintered hard metal to allow the continued use of weakly magnetisable hard metal, but contrary to the case of non-sintered hard metals, allow Vicker's Hardness of 1000 to 2000 to be attained. The sintered hard metal may be titanium or tungsten carbide with a
10 cobalt content of 2 to 20% by volume. These compositions have proven themselves particularly well in practice, whereby the cobalt is responsible for the magnetisability.

15 The diameter of the pin in a direction transverse to the longitudinal axis of the pole-piece is preferably $1/4$ to $2/3$ of the diameter of the pole-piece. Further, the pin may be several millimeters long and has a diameter of one millimeter or less.
20 Also the pin diameter may be $0.7 \text{ mm} \pm 50\%$ and the pole-piece diameter $1.6 \text{ mm} \pm 50\%$ in the case of a single-pole measuring probe. The radius of the spherical segment is from 0.6 to 3 times the diameter of the pole-piece. The linearization can be optimised with
25 respect to the measurement of curved parts and parts with small

surfaces areas.

The apparatus according to the invention can also be used as a single-pole probe. It is not restricted to use as a two-pole probe. If it is to be ^{used} ~~used~~ as a
 5 single-pole probe however, the additional problem of the stray magnetic field arises. This problem can be eliminated by ensuring that the pole-piece is positioned centrally in a pot core, its front face standing proud of the front face of the pot core wall,
 10 the inside wall of the pot core wall being clad with a foil composed of a material with a high magnetic permeability.

The invention is now described using preferred illustrative embodiments.

15 The accompanying drawings show:

FIG. 1: the substantially enlarged cross-section through a probe which has been set down on a coating or plating,

FIG. 2: the area around the contact surface,
 20 enlarged further in order to show better the direction of the magnetic field flux lines,

FIG. 3: a characteristic curve of coating thickness versus normalized voltage for two very

different materials plotted on a semi-logarithmic scale,

FIG. 4 shows the lower left hand part of the curve shown in Figure 3, enlarged and plotted with linear co-ordinates, and

FIG. 5: a cross-section, similar to Fig. 1, but for a two-pole probe.

Referring to Figure 1a pot core 11 composed of soft iron is rotationally symmetric about the geometrical longitudinal axis 12. It has a base 13 and a circular cylindrical wall 14. In the area of the base 13 there is a horizontal threaded through-bore 16. A grubscrew 17 is screwed into this bore. The base 13 has a through-bore 18 coaxial to the geometrical longitudinal axis 12 which has a diameter substantially smaller than that of the inner base surface 19 of the base 13. A circular cylindrical core 21 composed of high-permeability material is positioned in the upper section of the through-bore 18 as per Fig. 1. Its topface 22 is lined up with the top face 23 of the base 13. A plastic disc 24, which limits the depth to which the core 21 can be pushed into the through-bore and acts as a stop etc., is seated on the top face 22 as well as part of the top face 23. The core 21 is clamped into this position by screwing in the grubscrew 17. In the lower section of the core 21 as per Fig. 1

is a coaxial blind hole. In this hole is positioned a sintered hard-metal pin which is fixed in the axial direction. The pin is held in position either by a clamping device or by adhesive.

5 Referring to Figure 2, the bottom face 28 of the pin 27 is ground as a spherical cup. It is symmetrical about the longitudinal axis 12. The geometry of the bottom face 28 is continued into the bottom face 29 of the core 21. The bottom face 28, 29 is produced by
10 using a technique similar to that used in the optics industry for grinding convex lenses or for the manufacture of watch bezels. The bottom face 28 is therefore of polished quality.

It can be seen from Figures 1 and 2 that the bottom
15 face 31 of the wall 14 is higher than the highest point of the bottom face 29. The bottom face 28 is the actual contact surface.

The plastic disc 24 carries two terminals 32. These are connected to a constant alternating current
20 supply. The supply has a frequency of 25 Hz to 5kHz. The frequency cannot be changed, it is in fact permanently set. The applied alternating current is constant at about 3mA. An exciter winding 33 is supplied from the terminals 32. This winding is seated
25 on the core 21.

The plastic disc 24 carries two further terminals 34. These are connected to an induction winding which

is also seated on the core 21. In the illustrative embodiment the induction winding 36 is wound around the core 21 in the region of the pin 27, whereas the exciter winding 33 is wound about that region of the core 21 which does not have the blind hole 26.

The base surface 19 is covered with a coaxial circular disc 37 composed of high-permeability foil material which has a thickness of roughly 20 to 40 micrometers. The disc 37 has a circular hole 38 lined up with the through-bore 18, the edge of which is positioned on the circular cylindrical external surface of the core 21.

The inner surface 39 of the wall 14 is also lined with a cylinder 41 of the said foil. The top of this cylinder touches the disc 37. The bottom front face 41 is in line with the radial bottom face 31.

The core 21 stands perpendicular to the surface 42 of a coating 43, that has a thickness which is to be measured, that is non-magnetic and that has been deposited on a magnetisable substrate 44.

As can be seen from Figure 2, when in use, the lines of force 46 must be prevented from concentrating exclusively in the region of the geometrical longitudinal axis 12. In fact the lines of force 46 are pushed outwards as per the

realistic illustration in Fig. 2 so that in comparison to other cases in point, the magnetic flux lines run practically uniformly across the bottom face 28, 29. The magnetic flux density is not greatest at the point 5 of contact but rather in the stationary annulus surrounding the blind hole 26 and naturally, further up in the massive core 21.

The most favorable case for setting down the probe is when the geometrical longitudinal axis stands 10 perpendicular to the surface 42. The apparatus is, however, to a large extent insensitive to position even in such cases where the surface 42 contacts another point of the bottom face 28.

The bottom face 29 may not, however, contact the 15 surface 42, because in this case the old, unfavorable conditions would arise again. On the other hand, if the bottom face 29 were to contact the surface 42, the magnetic reluctance of the entire circuit would be so much lower that this would be easily detected and the 20 measurement recognised as faulty.

In Fig. 3 the thickness in micrometers is plotted on the logarithmic vertical axis. The normalized voltage U_n is plotted on the linear horizontal axis, whereby

$$U = U_0$$

$$U_n = \frac{U - U_0}{U_\infty - U_0}, \text{ where:}$$

$$U_\infty = U_0$$

5 U_0 is the voltage generated when the probe is set down on the substrate material 44 and the coating 43 is not present.

U_∞ is the voltage generated when the probe is raised in the air, whereby the distance it is raised is such that the probe is no longer
10 influenced by the magnetic substrate material 44.

U is the voltage which is generated by a measurable coating.

U_n therefore lies between 0 and 1.

It can be seen from Fig. 3 that only over a
15 particular length does the characteristic curve 47 for hardened steel lie a little above the characteristic curve 48 for soft iron. The deviation is in fact so small that the characteristic curve only appears to be slightly thicker in this region. In the remainder of
20 the range the characteristic curves 47, 48 are identical within the accuracy of the drawing. The similarity over the entire range is extremely favorable.

Fig. 4 shows the lower left corner of Fig. 3 on a linear scale. As can be confirmed by laying a straight edge on Fig. 4, the non-linear deviation is very slight, and the curves 47 and 48 have joined to become a single line. This means that there is a practically linear relationship between thickness and voltage independent of the substrate to be measured.

In the illustrative embodiment shown in Figures 1 and 2 the core 21 had a diameter of 1.6mm. The pin had a diameter of 0.7 mm. The radius of the bottom faces 28, 29 was 1.2 mm. With this probe values up to 1000 micrometer can be covered - naturally after the measuring ranges have been decided upon - whereby U_n can be as high as 0.9.

If the pot core 11 is clad with a foil as per the illustrative embodiment, exciter frequencies of up to 5 kHz can be applied to the exciter winding 33. In this manner the design can be still further reduced in size. This allows coatings to be measured in the range 0 to 100 micrometers largely independent of shape, even though, if they are metallic, they cause no noticeable eddy-current losses in this range. In this case of the said design the core 21 can have a diameter of 0.8 mm and the pin a diameter of 0.4 mm.

For core probes the inner surface 39 is 1 to 3 times the diameter of the core 21. The length of the pot core 11 lies between 0.5 to 2 times the diameter of the inner surface 39.

5 In the illustrative embodiment of a two-pole probe as per Fig. 5, analogous to the core 21 there are two cores 49, 51. The top faces of these cores are connected together by a yoke 52. The exciter winding 53 is positioned on the core 49 and the induction
10 winding 53 is positioned on the core 51. In this case two the pins 54, 56, analogous to pin 27, have the said geometry.

This type of two-pole probe is advantageous when measurements are to be made on rough surfaces. Since
15 the probability that both poles are positioned within a hollow or on a hump of the coating are slight, this type of probe averages the measuring effect in a desirable manner.

In addition, two-pole measuring probes have, if the
20 direction lines of force between the two poles can be imagined, an elliptical field, whereby the dependency on shape for measurements on cylindrical materials is much less than is the case for single-pole pot cores, which due to design considerations have a radially

(37)



- 16 -

CLAIMS

1. An electromagnetic measuring probe comprising at least one pole-piece composed of a magnetic material of high magnetic permeability, said pole-piece having a pole-piece front face, a recess machined into the pole-piece front face extending into the body of the pole-piece, and a pin composed of another material positioned within the recess, wherein the pin (27) is composed of hard metal which has a low magnetic permeability in comparison to the material of the pole-piece (21), and the external ~~front~~ face (28) of the pin (27) comprises a spherical segment contact surface for contacting a layer to be measured.
2. A measuring probe as claimed in claim 1, wherein the pin (27) and the pole-piece (21) are cylindrical.
3. A measuring probe as claimed in claim 1 or 2, wherein the pin (27) is composed of sintered hard metal.
4. A measuring probe as claimed in claim 3, wherein the sintered hard metal is titanium or tungsten carbide with a cobalt content of 2 to 20% by volume.
5. A measuring probe as claimed in claim 2, wherein



(34)

- 17 -

the diameter of the pin in a direction transverse to the longitudinal axis of the pole-piece (21) is $1/4$ to $2/3$ of the diameter of the pole-piece (21).

6. A measuring probe as claimed in claim 2, wherein
5 the pin (27) is several millimeters long and has a diameter of one millimeter or less.

7. A measuring probe as claimed in claim 6, wherein
the diameter of the pin (27) is $0.7 \text{ mm} \pm 50\%$ and the
10 diameter of the pole-piece (21) is $1.6 \text{ mm} \pm 50\%$ in the case of a single pole measuring probe.

8. A measuring probe as claimed in claim 2, wherein the
radius of the spherical segment is from 0.6 to 3 times
15 the diameter of the pole-piece (21).

9. A measuring probe as claimed in any one of claims 1
- 8, wherein the pole-piece (21) is positioned
centrally in a pot core (11), its front face (29)
standing proud of the front face (31) of the pot core
20 wall (14) and the inside wall (39) of the pot core wall
(14) is clad with a foil (35) composed of a material
with a high magnetic permeability.

10. A measuring probe as claimed in claim 1, having



- 18 -

two pole-pieces (49, 51) connected together by means of a yoke (52).

11. An electromagnetic measuring probe substantially
5 as described with reference to Figures 1 and 2 or
Figure 5 of the accompanying drawings.
