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Technical note

N. Murly

Thickness determination of anodized deposits and electrodeposits by Vickers indentation technique

© 1974 The Metals Society. Manuscript received 18 December 1972. The author is in the Metallurgical Engineering Department, Regional Engineering College, Jawaharlal Nehru Technological University, Warangal (A.P.), India.

Electrodeposit thickness is of prime importance and a test is therefore almost invariably included in specifications. Knowledge of the precise thickness of electrodeposits and anodized deposits is essential in corrosion, abrasion, and wear studies. In the literature there are numerous proposed methods¹⁻¹⁴ for determining electrodeposit thickness, which are neither simple nor rapid compared with the method described here.

Derivation

The standard Vickers indenter consists of a diamond in the form of a square-based pyramid with an included angle of 136° between opposite faces. The impression produced by such an indenter is shown in Fig.1. Where the diagonal, side, and height of the indentation are d , a , and h , respectively, the interrelation between these three can be expressed as:

$$h = d \cot 68^\circ \cdot \sqrt{2/4} = 0.1428 d$$

$$h = a \cot 68^\circ \cdot 1/2 = 0.202 a$$

and hence

$$h = 0.1428 d = 0.202 a.$$

Where the electrodeposit thickness is t and the dimensions of the diagonal and side before and after the removal of the electrodeposit are d_1 , a_1 , d_2 , and a_2 , respectively, the relationship between these can be written as:

$$t = h_1 - h_2 = 0.1428 (d_1 - d_2) = 0.202 (a_1 - a_2)$$

which is evident from Fig.1.

Experimental

An anodized, dyed aluminium sheet and an electrodeposited nickel-on-brass specimen 4 mm thick were taken. From each of the specimens a 25 × 25 mm piece was cut. These were mounted on a clear plastic self-setting resin. Four Vickers indentations were made on each of the specimens with 30 and 40 kg loads, respectively. Using 3/0 and 4/0 emery papers these were fine ground and later subjected to disc polishing for controlled removal of dyed anodized film and electrodeposit. Conventional ultrafine magnesia, suspended in water, was used as an abrasive for both the specimens. Disc polishing was continued in stages until the anodized film and electrodeposit were completely removed. This was best judged visually by colour difference.

Measurements

Measurement of the diagonals and sides of the indentations was made by a Filar micrometer eyepiece, which is accurate to ±0.001 mm.

In some cases there was difficulty in measuring the dimensions of the indentation because it was barreled. This was overcome by using smaller loads. Empirical corrections for the barreling effect proposed by Crow¹⁵ were used and compared.

Results and discussion

For each impression both the diagonals and sides were measured and the mean of each was tabulated. The measurements were carried out on each impression before and after the removal of the anodized and electrodeposited layer. The subscript (1) indicates the dimensions of the impression made on the electrodeposited layer and the subscript (2) indicates the same dimensions after its removal. The dimensions of the impressions are given in Table 1.

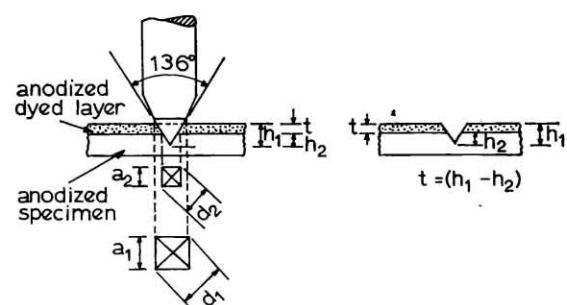
It is evident from this table that the results agree to three significant figures. It is also clear that the resultant thickness measurements based on the sides are slightly higher than those based on corresponding diagonal measurements. This may be due to the uncertainty of the side measurements arising from some barreling of the indentations.

Advantages of the method

The advantages of this method are:

- (i) it is simple and rapid
- (ii) local thicknesses of the electrodeposits and anodized films can be determined
- (iii) the thicknesses of electrodeposits and anodized films less than 3 µm can be measured very easily and accurately, because indentations are easy to measure accurately.

The method is relatively non-destructive. The degree to which the test is destructive to the finished part depends



1 Schematic diagram showing Vickers indentation and measuring technique

Table 1 Dimensions of the impressions

Drum reading			Drum reading			
d_1	d_2	t_d , mm	d_1/d_2	a_1	a_2	t_s , mm
<i>Anodized aluminium specimen</i>						
749	612	0.0268	1.22	529	433	0.0265
738	599	0.0271	1.23	522	424	0.0271
729	591	0.0269	1.23	523	421	0.0282
737	598	0.0271	1.23	521	422	0.0273
<i>Nickel-plated brass specimen</i>						
796	671	0.0244	1.186	562	474	0.0243
792	670	0.0238	1.182	560	473	0.0240
793	673	0.0234	1.178	561	475	0.0237
789	669	0.0234	1.179	558	473	0.0235
t_d =thickness calculated on the basis of diagonals						
t_s =thickness calculated on the basis of sides						

t_d =thickness calculated on the basis of diagonals
 t_s =thickness calculated on the basis of sides

upon the size of the indentation. Obviously, the smaller it is the less harmful it will be. The indentations at low loads are virtually invisible. Local thickness determination can be made without impairing the final use of the article.

Limitations

The method does have some limitations. In certain cases, the end point at which the coating is polished away would be difficult to detect, e.g. for a coating of nickel on steel or where the deposited metal and base metal are the same colour.

Local thickness determination on curved surfaces may

be somewhat difficult, but by making some corrections it is possible to determine this thickness.

Acknowledgments

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Survey of the heat treatment of engineering components

Dr T. Bell

One of the primary aims of the Heat Treatment Joint Committee of The Iron and Steel Institute, The Institute of Metals, and The Institution of Metallurgists has been to further the overall appreciation of the scientific principles and technological factors of heat-treatment practice. In keeping with this objective, the Committee instigated this survey, which was financed through the generosity of the British Steel Corporation in the form of a Heat Treatment Fellowship. The Survey was undertaken by Dr T. Bell of the University of Liverpool, and was intended to provide an 'informed opinion' of various processes, industries, and technical and educational establishments which are concerned with heat treatment.

The survey is based on an assessment of the technical literature in this field and on discussions which took place during visits to over 45 organizations in the UK, Europe, and the USA. The scope of the survey is vast, and some subjects are therefore mentioned only briefly, with reference given to more authoritative bodies, while others are dealt with at length, if in the opinion of the Heat Treatment Fellow this is felt to be justified. The subjects chosen for 'in-depth' comment are usually new processes on which information is not readily available, possible future developments, and opinions on various factors which influence the progress of the theory and practice of heat treatment.

The report is divided into six sections: classification and definitions of heat-treatment processes; austenitic thermochemical treatments; ferritic thermochemical treatments; selected general heat-treatment topics; heat-treatment education and information dissemination; conclusions and recommendations (this section summarizes and highlights some of the main features of the survey, and has also been prepared as a separate report for extensive circulation).

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