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**Paper and board — Determination  
of roughness/smoothness (air leak  
methods) —**

**Part 4:  
Print-surf method**

**iTEH Standards**  
Papier et carton — Détermination de la rugosité/du lissé (méthodes  
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Reference number  
ISO 8791-4:2021(E)

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Published in Switzerland

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## Foreword

ISO (the International Organization for Standardization) is a worldwide federation of national standards bodies (ISO member bodies). The work of preparing International Standards is normally carried out through ISO technical committees. Each member body interested in a subject for which a technical committee has been established has the right to be represented on that committee. International organizations, governmental and non-governmental, in liaison with ISO, also take part in the work. ISO collaborates closely with the International Electrotechnical Commission (IEC) on all matters of electrotechnical standardization.

The procedures used to develop this document and those intended for its further maintenance are described in the ISO/IEC Directives, Part 1. In particular, the different approval criteria needed for the different types of ISO documents should be noted. This document was drafted in accordance with the editorial rules of the ISO/IEC Directives, Part 2 (see [www.iso.org/directives](http://www.iso.org/directives)).

Attention is drawn to the possibility that some of the elements of this document may be the subject of patent rights. ISO shall not be held responsible for identifying any or all such patent rights. Details of any patent rights identified during the development of the document will be in the Introduction and/or on the ISO list of patent declarations received (see [www.iso.org/patents](http://www.iso.org/patents)).

Any trade name used in this document is information given for the convenience of users and does not constitute an endorsement.

For an explanation of the voluntary nature of standards, the meaning of ISO specific terms and expressions related to conformity assessment, as well as information about ISO's adherence to the World Trade Organization (WTO) principles in the Technical Barriers to Trade (TBT), see [www.iso.org/iso/foreword.html](http://www.iso.org/iso/foreword.html).

(<https://standards.iteh.ai>)

This document was prepared by Technical Committee ISO/TC 6, *Paper, board and pulps*, Subcommittee SC 2, *Test methods and quality specifications for paper and board*.

This third edition cancels and replaces the second edition (ISO 8791-4:2007), which has been technically revised.

[ISO 8791-4:2021](https://standards.iteh.ai/iso/8791-4:2021)

The main changes compared to the previous edition are as follows:

- Annex D and Annex E describing the calibration of Print-surf instruments have been removed;
- some minor editorial changes have been made.

A list of all parts in the ISO 8791 series can be found on the ISO website.

Any feedback or questions on this document should be directed to the user's national standards body. A complete listing of these bodies can be found at [www.iso.org/members.html](http://www.iso.org/members.html).

# Paper and board — Determination of roughness/ smoothness (air leak methods) —

## Part 4: Print-surf method

### 1 Scope

This document specifies a method for determining the roughness of paper and board using an apparatus which conforms to the Print-surf method, as defined in this document. It is applicable to all printing papers and boards with which it is possible to form a substantially airtight seal against the guard lands of the measuring head.

### 2 Normative references

The following documents are referred to in the text in such a way that some or all of their content constitutes requirements of this document. For dated references, only the edition cited applies. For undated references, the latest edition of the referenced document (including any amendments) applies.

ISO 186, *Paper and board — Sampling to determine average quality*

ISO 187, *Paper, board and pulps — Standard atmosphere for conditioning and testing and procedure for monitoring the atmosphere and conditioning of samples*

### 3 Terms and definitions

[ISO 8791-4:2021](#)

For the purposes of this document, the following terms and definitions apply.

ISO and IEC maintain terminological databases for use in standardization at the following addresses:

- ISO Online browsing platform: available at <https://www.iso.org/obp>
- IEC Electropedia: available at <http://www.electropedia.org/>

#### 3.1

##### **print-surf roughness**

mean gap between a sheet of paper or board and a flat circular land pressed against it under specified conditions

Note 1 to entry: The mean gap is expressed as the cube root mean cube gap calculated as specified in [Annex A](#). The Print-surf roughness is expressed directly as the average value of roughness, in micrometres.

#### 3.2

##### **print-surf compressibility**

**K**

percentage decrease in surface roughness when measurements are made consecutively at the two standard clamping pressures specified in this document

### 4 Principle

The test piece is placed between a circular flat metal sensing surface and a resilient backing, and inner and outer circular lands form a seal with the test piece. Under the influence of a pressure difference,

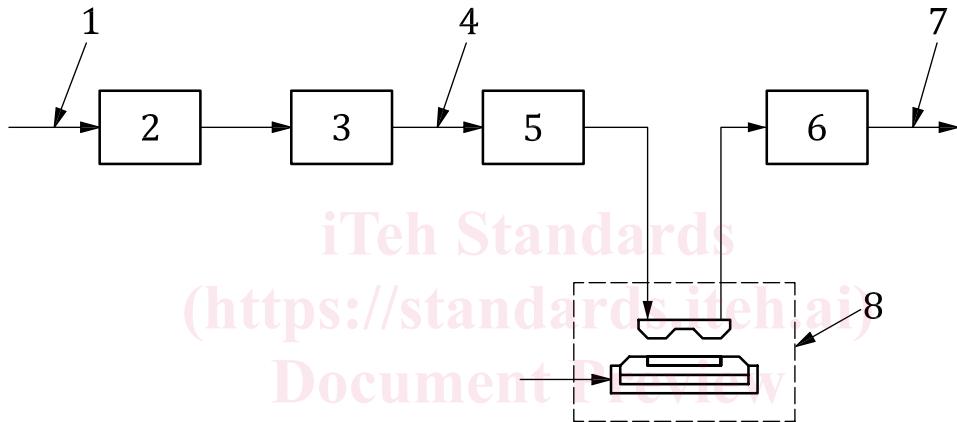
air flows across the measuring land between the measuring land and the test piece. The rate of air flow is measured on a variable-area flowmeter, or the pressure difference across the measuring land is compared to the pressure difference across a known impedance. In both cases, the result is expressed as the air gap, in micrometres.

## 5 Apparatus

### 5.1 Print-surf tester (two types)

5.1.1 **Print-surf tester**, which operates according to one of the following principles.

5.1.1.1 **Variable-area flowmeter type**, in which a standard pressure difference is created across the measuring land and the air-flow rate is measured on a variable-area flowmeter. The air-flow rate varies with roughness and the flow rate is converted to roughness, in micrometres. The flow diagram for this type of instrument is shown in [Figure 1](#).



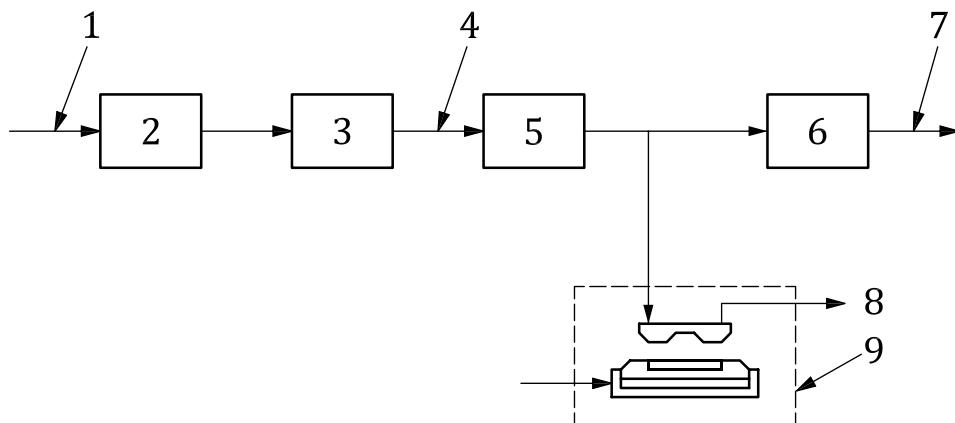
#### Key

|   |                                   |  |
|---|-----------------------------------|--|
| 1 | incoming air — 300 kPa to 600 kPa | <a href="https://standards.iteh.ai/catalog/standards/iso/f7b1589b-799e-4012-abcf-fca432457b32/iso-8791-4-2021">ISO 8791-4:2021</a> |
| 2 | filter                            |  |
| 3 | pressure-regulator valve          |  |
| 4 | 6,2 kPa or 19,6 kPa               |  |
| 5 | on/off valve                      |  |
| 6 | flow indicator tubes              |  |
| 7 | to atmosphere                     |  |
| 8 | sensing head and clamping device  |  |

**Figure 1 — Flow diagram for variable-area flowmeter type**

5.1.1.2 **Impedance type**, in which the air from the controlled pressure source passes first through a fluidic impedance and then through the sensing head, after which it discharges to atmosphere. The pressure differences across the fluidic impedance and across the land are each measured by a

transducer. These pressure differences vary with roughness and the signals are converted to roughness, in micrometres. The flow diagram for this type of instrument is shown in [Figure 2](#).



#### Key

- 1 incoming air — 300 kPa to 600 kPa
- 2 filter
- 3 pressure-regulator valve
- 4 19,6 kPa
- 5 fluidic impedance
- 6 pressure transducer
- 7 analogue signal
- 8 to atmosphere
- 9 sensing head and clamping device

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**Figure 2 — Flow diagram for impedance instrument type**

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[5.1.2](#) The procedures for maintaining these testers in good working order given in [Annex B](#) apply.

## 5.2 Principal components of the system

**5.2.1 Air supply**, in which the air from the controlled pressure source passes first through a fluidic impedance and then through a pressure transducer.

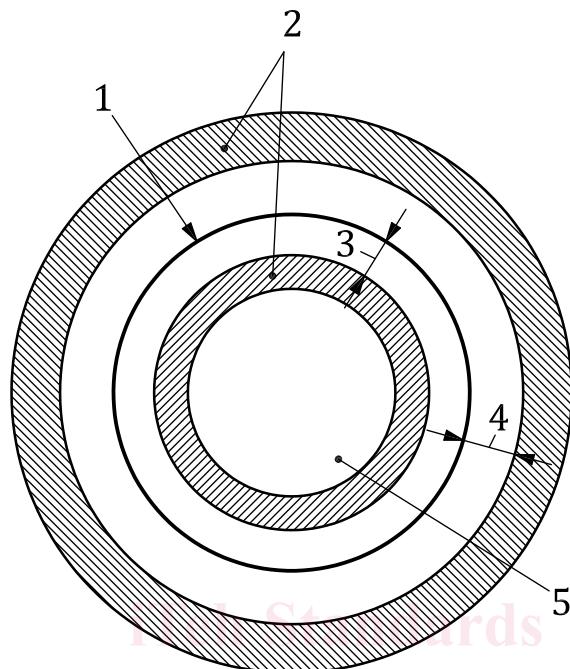
**5.2.2 Sensing-head pressure regulator**, allowing setting of the sensing-head differential pressure to  $19,6 \text{ kPa} \pm 0,1 \text{ kPa}$  or, on variable-area flowmeter instruments only, to either  $6,2 \text{ kPa} \pm 0,1 \text{ kPa}$  or  $19,6 \text{ kPa} \pm 0,1 \text{ kPa}$ .

**5.2.3 Sensing head**, (see [Figures 3](#) and [4](#)), consisting of three concentric, annular lands composed of suitable material which have coplanar, polished surfaces. The centre or measuring land shall be  $51,0 \mu\text{m} \pm 1,5 \mu\text{m}$  wide and have an effective length of  $98,0 \text{ mm} \pm 0,5 \text{ mm}$ . The two guard lands shall each be at least  $1\,000 \mu\text{m}$  wide at any point, and the radial distance between them at any point shall be  $152 \mu\text{m} \pm 10 \mu\text{m}$ . The measuring land shall be centred between them to within  $\pm 10 \mu\text{m}$ .

The lands shall be mounted in an airtight mounting, constructed so that air can be passed into the gap between one guard land and the measuring land, and exhausted from the gap between the measuring land and the other guard land. The back of the mounting shall be flat and form a ground mating surface with the flat surface of a manifold fitted with air inlet and outlet ports.

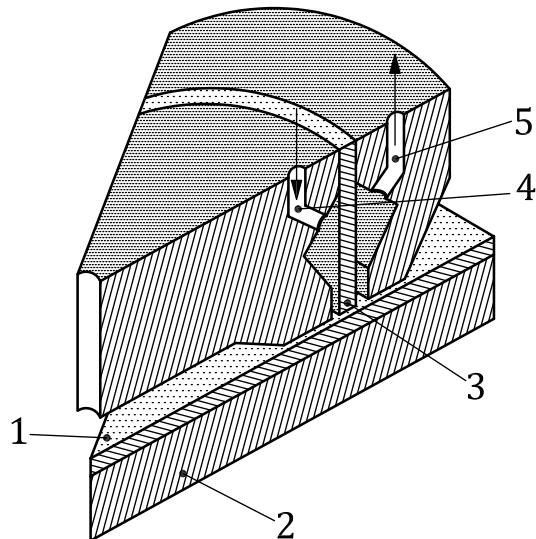
A spring-loaded protective collar may be fitted outside the guard lands. If such a protective collar is fitted, the force exerted by the loading spring shall be taken into account when setting the clamping pressure.

NOTE In many instruments fitted with the protective collar, the force exerted by the loading spring is 9,8 N.



| Key |   |
|-----|---|
| 1   | measuring land  |
| 2   | guard lands   |
| 3   | passage air connected to air supply   |
| 4   | passage leading to flowmeters or atmosphere <a href="#">ISO 8791-4:2021</a>   |
| 5   | <a href="http://fluidic impedance standards.iteh.ai/catalog/standards/iso/f7b1589b-799e-4012-abcf-fca432457b32/iso-8791-4-2021">http://fluidic impedance standards.iteh.ai/catalog/standards/iso/f7b1589b-799e-4012-abcf-fca432457b32/iso-8791-4-2021</a> |

**Figure 3 — Plan of the measuring and guard lands of the sensing head**

**Key**

- 1 paper
- 2 resilient backing
- 3 measuring land
- 4 regulated low-pressure air
- 5 to flowmeters or atmosphere

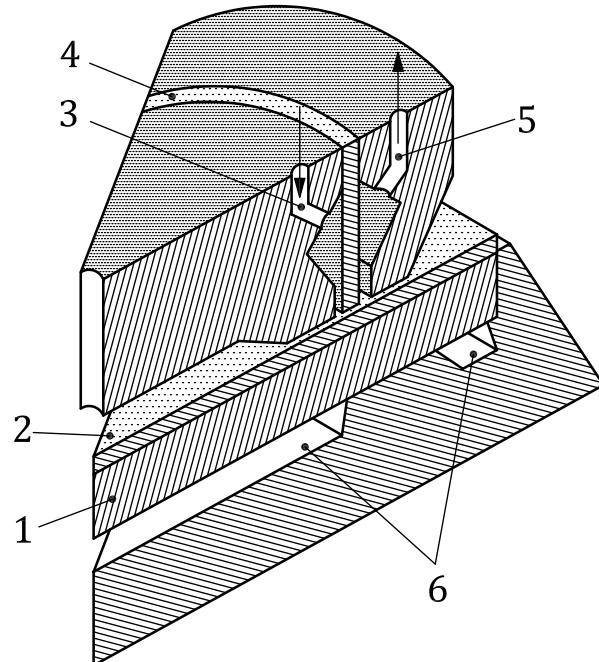
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**Figure 4 — The sensing head sectioned on two radii**

**5.2.4 Backing holders**, consisting of rigid metal discs of known mass, each recessed to accommodate a resilient backing at least 10 mm greater in diameter than the outside diameter of the outer guard land. The mass of both the resilient backing and the holder shall be allowed for in the initial adjustment of the clamping pressure.

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It has been observed that high-stiffness papers and boards can interact negatively with the flat metal backing holder and cause erroneously high roughness results. This problem can be solved by using a modified backing holder which relieves those areas of the backing holder not directly below the measuring land, as shown in [Figure 5](#).

**Key**

- 1 resilient backing
- 2 paper
- 3 regulated low-pressure air
- 4 measuring lands
- 5 to flowmeters or atmosphere
- 6 new modified clamp platen showing machined cut-away

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**Figure 5 — The sensing head sectioned on two radii showing cut-away platen**

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**5.2.5 Two resilient backings**, of different types, which can be held in the recessed holders by means of double-sided adhesive tape:

**5.2.5.1 Soft backing**, resilient, consisting of an offset printing blanket composed of a layer of synthetic rubber, at least 600 µm thick, bonded to a fabric backing giving an overall thickness of 2 000 µm  $\pm$  200 µm. The apparent hardness of the complete backing shall be 83 IRHD  $\pm$  6 IRHD (International Rubber Hardness Degrees).

**5.2.5.2 Hard backing**, resilient, usually made from a polyester film bonded at its periphery to cork, offset blanket or similar material. A small exhaust hole shall be provided to prevent air being trapped between the film and the backing. The apparent hardness of the assembly shall be 95 IRHD  $\pm$  2 IRHD.

**5.2.6 Clamping mechanism**, allowing clamping of the resilient backing at pressures of either 980 kPa  $\pm$  30 kPa or 1960 kPa  $\pm$  30 kPa, the pressure being calculated from the total area of the measuring and guard lands.

**NOTE 1** On some earlier instruments, these values can be displayed on the gauge as 10 kgf/cm<sup>2</sup> and 20 kgf/cm<sup>2</sup>.