

Optical Measurement of Surface Topography

Richard Leach (Ed.)

Optical Measurement of Surface Topography

Editor

Prof. Richard Leach
National Physical Laboratory
(NPL)
Industry & Innovation Div.
Hampton Road
TW11 0LW Teddington, Middlx.
United Kingdom
E-mail: richard.leach@npl.co.uk

ISBN 978-3-642-12011-4

e-ISBN 978-3-642-12012-1

DOI 10.1007/978-3-642-12012-1

Library of Congress Control Number: 2011924476

© 2011 Springer-Verlag Berlin Heidelberg

This work is subject to copyright. All rights are reserved, whether the whole or part of the material is concerned, specifically the rights of translation, reprinting, reuse of illustrations, recitation, broadcasting, reproduction on microfilm or in any other way, and storage in data banks. Duplication of this publication or parts thereof is permitted only under the provisions of the German Copyright Law of September 9, 1965, in its current version, and permission for use must always be obtained from Springer. Violations are liable to prosecution under the German Copyright Law.

The use of general descriptive names, registered names, trademarks, etc. in this publication does not imply, even in the absence of a specific statement, that such names are exempt from the relevant protective laws and regulations and therefore free for general use.

Typesetting: Data supplied by the authors

Cover Design: Scientific Publishing Services Pvt. Ltd., Chennai, India

Printed on acid-free paper

9 8 7 6 5 4 3 2 1

springer.com

Preface

The measurement and characterisation of areal surface topography is becoming crucial to many modern manufacturing methods. The control of areal surface structure allows a manufacturer to radically alter the functionality of a part. Examples include structuring to effect fluidics, optics, tribology, aerodynamics and biology. To control such manufacturing methods requires appropriate measurement strategies. There is also soon to be the introduction of a series of ISO specification standards in this area and this book will become a companion guide to these standards. These new standards are many and complex, as are the new measurement techniques, so industry will hopefully benefit from such a book.

There is now a wealth of new optical techniques on the market, or being developed in academia, that can measure areal surface topography. Each method has its strong points and limitations. This book will start with introductory chapters on optical instruments, their common language, generic features and limitations, and their calibration. Each type of modern optical instrument will then be described (in a common format) by experts in the field.

Acknowledgements

First and foremost I would like to thank all the chapter authors for their hard work and dedication to this book and David Flack (NPL) for reviewing some of the chapters. I also have to thank my beautiful wife for allowing me to spend hours writing and days travelling in order to become an expert in such an international field – thanks Sharmin. Last, but not least, my parents, sisters, son and step son also need to be thanked for their unwavering support.

This book is dedicated to the first engineer I ever met and the one that I want to please the most – thanks dad!

Contents

1	Introduction to Surface Texture Measurement	1
	<i>Richard Leach</i>	
1.1	Surface Texture Measurement.....	1
1.2	Surface Profile and Areal Measurement.....	2
1.3	Areal Surface Texture Measurement.....	2
1.4	Surface Texture Standards and GPS.....	3
1.4.1	Profile Standards	3
1.4.2	Areal Specification Standards.....	4
1.5	Instrument Types in the ISO 25178 Series	5
1.5.1	The Stylus Instrument.....	7
1.5.2	Scanning Probe Microscopes.....	8
1.5.3	Scanning Electron Microscopes	9
1.5.4	Optical Instrument Types	9
1.6	Considerations When Choosing a Method	10
	Acknowledgements	11
	References	11
2	Some Common Terms and Definitions.....	15
	<i>Richard Leach</i>	
2.1	Introduction	15
2.2	The Principal Aberrations	15
2.3	Objective Lenses.....	17
2.4	Magnification and Numerical Aperture	18
2.5	Spatial Resolution.....	19
2.6	Optical Spot Size	20
2.7	Field of View	21
2.8	Depth of Field and Depth of Focus.....	21
2.9	Interference Objectives	22
	Acknowledgements	22
	References	22
3	Limitations of Optical 3D Sensors	23
	<i>Gerd Häusler, Svenja Ettl</i>	
3.1	Introduction: What Is This Chapter About?	23
3.2	The Canonical Sensor.....	24

3.3	Optically Rough and Smooth Surfaces	25
3.4	Type I Sensors: Triangulation	27
3.5	Type II and Type III Sensors: Interferometry	33
3.6	Type IV Sensors: Deflectometry	38
3.7	Only Four Sensor Principles?	42
3.8	Conclusion and Open Questions.....	43
	References	45
4	Calibration of Optical Surface Topography Measuring Instruments	49
	<i>Richard Leach, Claudiu Giusca</i>	
4.1	Introduction to Calibration and Traceability	49
4.2	Calibration of Surface Topography Measuring Instruments	50
4.3	Can an Optical Instrument Be Calibrated?	51
4.4	Types of Material Measure.....	52
4.5	Calibration of Instrument Scales	54
4.5.1	Noise	56
4.5.2	Residual Flatness.....	58
4.5.3	Amplification, Linearity and Squareness of the Scales	59
4.5.4	Resolution	63
4.6	Relationship between the Calibration, Adjustment and Measurement Uncertainty	66
4.7	Summary	67
	Acknowledgements	68
	References	69
5	Chromatic Confocal Microscopy	71
	<i>François Blateyron</i>	
5.1	Basic Theory	71
5.1.1	Confocal Setting	72
5.1.2	Axial Chromatic Dispersion	73
5.1.3	Spectral Decoding	75
5.1.4	Height Detection	76
5.1.5	Metrological Characteristics.....	77
5.1.5.1	Spot Size	77
5.2	Instrumentation.....	78
5.2.1	Lateral Scanning Configurations	78
5.2.1.1	Profile Measurement	78
5.2.1.2	Areal Measurement	80
5.2.2	Optoelectronic Controller.....	81
5.2.3	Optical Head.....	83
5.2.4	Light Source	84
5.2.5	Chromatic Objective.....	85
5.2.6	Spectrometer.....	86
5.2.7	Optical Fibre Cord.....	87

5.3	Instrument Use and Good Practice	87
5.3.1	Calibration.....	87
5.3.1.1	Calibration of Dark Level.....	87
5.3.1.2	Linearisation of the Response Curve	88
5.3.1.3	Calibration of the Height Amplification Coefficient....	90
5.3.1.4	Calibration of the Lateral Amplification Coefficient	90
5.3.1.5	Calibration of the Hysteresis in Bi-directional Measurement.....	90
5.3.2	Preparation for Measurement	91
5.3.3	Pre-processing	91
5.4	Limitations of the Technique.....	91
5.4.1	Local Slopes	91
5.4.2	Scanning Speed	94
5.4.3	Light Intensity	94
5.4.4	Non-measured Points.....	94
5.4.5	Outliers	95
5.4.6	Interference.....	96
5.4.7	Ghost Foci	96
5.5	Extensions of the Basic Principles.....	97
5.5.1	Thickness Measurement	97
5.5.2	Line and Field Sensors	99
5.5.3	Absolute Reference	99
5.6	Case Studies	100
	Acknowledgements	105
	References	105
6	Point Autofocus Instruments	107
	<i>Katsuhiro Miura, Atsuko Nose</i>	
6.1	Basic Theory.....	107
6.2	Instrumentation.....	112
6.3	Instrument Use and Good Practice	114
6.3.1	Comparison with Roughness Material Measures	114
6.3.2	Three-Dimensional Measurement of Grinding Wheel Surface Topography	117
6.4	Limitations of PAI.....	118
6.4.1	Lateral Resolution	118
6.4.2	Vertical Resolution.....	119
6.4.3	The Maximum Acceptable Local Surface Slope.....	120
6.5	Extensions of the Basic Principles.....	122
6.6	Case Studies	126
6.7	Conclusion.....	128
	References	128
7	Focus Variation Instruments	131
	<i>Franz Helmli</i>	
7.1	Introduction	131

7.2	Basic Theory	131
7.2.1	How Does It Work?	131
7.2.2	Acquisition of Image Data	133
7.2.3	Measurement of 3D Information	133
7.2.4	Post-processing	137
7.2.5	Handling of Invalid Points	139
7.3	Difference to Other Techniques	139
7.3.1	Difference to Imaging Confocal Microscopy	140
7.3.2	Difference to Point Auto Focusing Techniques	140
7.4	Instrumentation	140
7.4.1	Optical System	141
7.4.2	CCD Sensor	141
7.4.3	Light Source	142
7.4.4	Microscope Objective	144
7.4.5	Driving Unit	144
7.4.6	Practical Instrument Realisation	145
7.5	Instrument Use and Good Practice	148
7.6	Limitations of the Technology	153
7.6.1	Translucent Materials	153
7.6.2	Measurable Surfaces	153
7.7	Extensions of the Basic Principles	154
7.7.1	Repeatability Information	154
7.7.2	High Radiometric Data Acquisition	155
7.7.3	2D Alignment	156
7.7.4	3D Alignment	157
7.8	Case Studies	160
7.8.1	Surface Texture Measurement of Worn Metal Parts	160
7.8.2	Form Measurement of Complex Tap Parameters	162
7.9	Conclusion	166
	Acknowledgements	166
	References	166
8	Phase Shifting Interferometry	167
	<i>Peter de Groot</i>	
8.1	Concept and Overview	167
8.2	Principles of Surface Measurement Interferometry	168
8.3	Phase Shifting Method	171
8.4	Phase Unwrapping	173
8.5	Phase Shifting Error Analysis	174
8.6	Interferometer Design	175
8.7	Lateral Resolution	178
8.8	Focus	181
8.9	Light Sources	182
8.10	Calibration	183
8.11	Examples of PSI Measurement	184
	References	185

9 Coherence Scanning Interferometry	187
<i>Peter de Groot</i>	
9.1 Concept and Overview	187
9.2 Terminology	189
9.3 Typical Configurations of CSI	190
9.4 Signal Formation	191
9.5 Signal Processing.....	197
9.6 Foundation Metrics and Height Calibration for CSI	201
9.7 Dissimilar Materials	201
9.8 Vibrational Sensitivity.....	202
9.9 Transparent Films.....	203
9.10 Examples	205
9.11 Conclusion.....	206
References	206
10 Digital Holographic Microscopy	209
<i>Tristan Colomb, Jonas Kühn</i>	
10.1 Introduction	209
10.2 Basic Theory.....	210
10.2.1 Acquisition.....	211
10.2.2 Reconstruction	211
10.3 Instrumentation.....	214
10.3.1 Light Source.....	215
10.3.2 Digital Camera	216
10.3.3 Microscope Objective	216
10.3.4 Optical Path Retarder.....	216
10.4 Instrument Use and Good Practice	217
10.4.1 Digital Focusing.....	217
10.4.2 DHM Parameters	218
10.4.3 Automatic Working Distance in Reflection DHM.....	218
10.4.4 Sample Preparation and Immersion Liquids	219
10.5 Limitations of DHM	219
10.5.1 Parasitic Interferences and Statistical Noise	219
10.5.2 Height Measurement Range.....	220
10.5.3 Sample Limitation.....	220
10.6 Extensions of the Basic DHM Principles	220
10.6.1 Multi-wavelength DHM.....	221
10.6.1.1 Extended Measurement Range	221
10.6.1.2 Mapping	222
10.6.2 Stroboscopic Measurement	222
10.6.3 DHM Reflectometry	223
10.6.4 Infinite Focus	224
10.6.5 Applications of DHM.....	224
10.6.5.1 Topography and Defect Detection.....	224
10.6.5.2 Roughness	225
10.6.5.3 Micro-optics Characterization.....	228

10.6.5.4 MEMS and MOEMS	229
10.6.5.5 Semi-transparent Micro-structures	230
10.7 Conclusions.....	232
References	232
11 Imaging Confocal Microscopy	237
<i>Roger Artigas</i>	
11.1 Basic Theory.....	237
11.1.1 Introduction to Imaging Confocal Microscopes.....	237
11.1.2 Working Principle of an Imaging Confocal Microscope	238
11.1.3 Metrological Algorithm	241
11.1.4 Image Formation of a Confocal Microscope.....	242
11.1.4.1 General Description of a Scanning Microscope	242
11.1.4.2 Point Spread Function for the Limiting Case of an Infinitesimally Small Pinhole	245
11.1.4.3 Pinhole Size Effect	246
11.2 Instrumentation.....	249
11.2.1 Types of Confocal Microscopes.....	250
11.2.1.1 Laser Scanning Confocal Microscope Configuration	250
11.2.1.2 Disc Scanning Confocal Microscope Configuration	253
11.2.1.3 Programmable Array Scanning Confocal Microscope Configuration	256
11.2.2 Objectives for Confocal Microscopy	259
11.2.3 Vertical Scanning.....	262
11.2.3.1 Motorised Stages with Optical Linear Encoders	262
11.2.3.2 Piezoelectric Stages.....	263
11.2.3.3 Comparison between Motorised and Piezoelectric Scanning Stages.....	264
11.3 Instrument Use and Good Practice	265
11.3.1 Location of an Imaging Confocal Microscope.....	265
11.3.2 Setting Up the Sample	265
11.3.3 Setting the Right Scanning Parameters	265
11.3.4 Simultaneous Detection of Confocal and Bright Field Images	267
11.3.5 Sampling	268
11.3.6 Low Magnification against Stitching	269
11.4 Limitations of Imaging Confocal Microscopy.....	270
11.4.1 Maximum Detectable Slope on Smooth Surfaces.....	270
11.4.2 Noise and Resolution in Imaging Confocal Microscopes	272
11.4.3 Errors in Imaging Confocal Microscopes	274
11.4.3.1 Objective Flatness Error	274
11.4.3.2 Calibration of the Flatness Error	275
11.4.3.3 Measurements on Thin Transparent Materials	276
11.4.4 Lateral Resolution.....	276

11.5	Measurement of Thin and Thick Film with Imaging Confocal Microscopy.....	278
11.5.1	Introduction.....	278
11.5.2	Thick Films	278
11.5.3	Thin Films.....	280
11.6	Case Study: Roughness Prediction on Steel Plates.....	283
	References	285
12	Light Scattering Methods	287
	<i>Theodore V. Vorburger, Richard Silver, Rainer Brodmann, Boris Brodmann, Jörg Seewig</i>	
12.1	Introduction	287
12.2	Basic Theory.....	289
12.3	Instrumentation and Case Studies.....	295
12.3.1	Early Developments.....	295
12.3.2	Recent Developments in Instrumentation for Mechanical Engineering Manufacture	298
12.3.3	Recent Developments in Instrumentation for Semiconductor Manufacture (Optical Critical Dimension).....	302
12.4	Instrument Use and Good Practice	308
12.4.1	SEMI MF 1048-1109 (2009) Test Method for Measuring the Effective Surface Roughness of Optical Components by Total Integrated Scattering	308
12.4.2	SEMI ME1392-1109 (2009) Guide for Angle-Resolved Optical Scatter Measurements on Specular or Diffuse Surfaces.....	310
12.4.3	ISO10110-8: 2010 Optics and Photonics — Preparation of Drawings for Optical Elements and Systems — Part 8: Surface Texture	311
12.4.4	Standards for Gloss Measurement	312
12.4.5	VDA Guideline 2009, Geometrische Produktspezifikation Oberflächenbeschaffenheit Winkelaufgelöste Streulichtmesstechnik Definition, Kenngrößen und Anwendung (Light Scattering Measurement Technique)	312
12.5	Limitations of the Technique.....	314
12.6	Extensions of the Basic Principles.....	314
	Acknowledgements	315
	References	315
	Index	319