QUALANOD
Sample report form for the laboratory testing of a new process

General information

Report Number	*XXXXX*
Date of report	*XXth MONTH 20XX*
Number of pages	*XX*
Type of inspection **→Granting** **→Renewal** **→if yes:**	 yes / no yes / no please indicate the QND-Nr.: **QND-…….** please indicate any **changes** made since the **initial** application: …… …… ……
Name of the system	XXXXX
Type of product	XXXXX

Inspection

Date of specimen preparation	*XXth MONTH 20XX*
Location and facilities used for specimen preparation **(see General Regulations VI-7)**	*XXXXX* *XXXXX*
Representative of the testing institute at the specimen preparation	*NAME / JOB TITLE*
Date of laboratory testing by the testing institute	*XXth to XXth MONTH 20XX*

Involved parties

Instructed by ……. **(the applicant)**	*COMPANY* *ADDRESS* *COUNTRY*
Testing institute	*COMPANY* *ADDRESS* *COUNTRY*
QUALANOD general licensee (or QUALANOD secretariat)	*COMPANY* *ADDRESS* *COUNTRY*

Introduction

The procedure for the approval of new processes, for which a new or renewed approval is sought from QUALANOD, is given in General Regulations VI. Its provisions shall be followed. This document is a sample report form for the results of the laboratory testing.

The testing institute named above has been authorized by QUALANOD to carry out the assessment of new processes for architectural anodizing according to General Regulations VI and Specifications Chapter 10.

Specimen Preparation

The alloy used was EN AW *XXXX* or AA *XXXX*.

The following process cycle was used:

Table 1 - Description of the process cycle

Step	**Process Name**	**Time t in min. / Temperature T in °C, current density or voltage for anodzing, pH for sealing**	**Concentration or Conductivity**
1 Degreasing	*XXXX*	*XX* / *XX*	*XXX* g / l
2 Rinsing	Tap water	*XX* / *XX*	*XXX* µS / cm
3 Etching	*XXXX*	*XX* / *XX*	*XXX* g / l
4 Rinsing	Tap water	*XX* / *XX*	*XXX* µS / cm
5 Deoxidizing	*XXXX*	*XX* / *XX*	*XXX* g / l
6 Rinsing	Tap water	*XX* / *XX*	*XXX* µS / cm
7 Rinsing	Deionized water	*XX* / *XX*	*XXX* µS / cm
8 Anodizing	*XXXX*	*XX* min / µm *XX* *XX* A/dm^2 *XX* volts	*XXX* g / l
9 Rinsing	Tap water	*XX* / *XX*	*XXX* µS / cm
10 Rinsing	DI- water	*XX* / *XX*	*XXX* µS / cm
11 Colouring	*XXXX*	*XX* / *XX*	*XXX* ml / l
12 Sealing	*XXXX*	*XX* min / µm *XX* pH *XXX*	*XXX* ml / l
13 New process	*XXXX*	*Give process parameters that vary from those of the reference process*	

Sample Details

Standard Process (S)

Label / No.:	Nominal thickness:	Colour	Test:
S15U1	15 µm	Natural (C0)	Thickness / Mass Loss Test
S15U2			
S15U3			
S15C1	15 µm	Dark Bronze (C34)	Thickness / Mass Loss Test
S15C2			
S15C3			
S20U1	20 µm	Natural (C0)	Thickness / Mass Loss Test
S20U2			
S20U3			
S20C1	20 µm	Dark Bronze (C34)	Thickness / Mass Loss Test
S20C2			
S20C3			
S15U4	15 µm	Natural (C0)	Thickness / Admittance / Dye Spot / Surface Abrasion Resistance Test
S15U5			
S15U6			
S15C4	15 µm	Dark Bronze (C34)	Thickness / Admittance / Surface Abrasion Resistance Test
S15C5			
S15C6			

Label / No.:	Nominal thickness:	Colour	Test:
S20U4 S20U5 S20U6	20 µm	Natural (C0)	Thickness / Admittance / Dye Spot / Surface Abrasion Resistance Test
S20C4 S20C5 S20C6	20 µm	Dark Bronze (C34)	Thickness / Admittance / Surface Abrasion Resistance Test
S15U7 S15U8 S15U9	15 µm	Natural (C0)	Thickness / Acetic Acid Salt Spray Test (AASS)
S15C7 S15C8 S15C9	15 µm	Dark Bronze (C34)	Thickness / Acetic Acid Salt Spray Test (AASS)
S20U7 S20U8 S20U9	20 µm	Natural (C0)	Thickness / Acetic Acid Salt Spray Test (AASS)
S20C7 S20C8 S20C9	20 µm	Dark Bronze (C34)	Thickness / Acetic Acid Salt Spray Test (AASS)

New Process (N)

Label / No.:	Nominal thickness:	Colour:	Test:
N15U1 N15U2 N15U3	15 µm	Natural (C0)	Thickness / Mass Loss Test
N15C1 N15C2 N15C3	15 µm	Dark Bronze (C34)	Thickness / Mass Loss Test
N20U1 N20U2 N20U3	20 µm	Natural (C0)	Thickness / Mass Loss Test
N20C1 N20C2 N20C3	20 µm	Dark Bronze (C34)	Thickness / Mass Loss Test
N15U4 N15U5 N15U6	15 µm	Natural (C0)	Thickness / Admittance / Dye Spot / Surface Abrasion Resistance Test
N15C4 N15C5 N15C6	15 µm	Dark Bronze (C34)	Thickness / Admittance / Surface Abrasion Resistance Test

Label / No.:	Thickness:	Colour:	Test:
N20U4 N20U5 N20U6	20 µm	Natural (C0)	Thickness / Admittance / Dye Spot / Surface Abrasion Resistance Test
N20C4 N20C5 N20C6	20 µm	Dark Bronze (C34)	Thickness / Admittance / Surface Abrasion Resistance Test
N15U7 N15U8 N15U9	15 µm	Natural (C0)	Thickness / Acetic Acid Salt Spray Test (AASS)
N15C7 N15C8 N15C9	15 µm	Dark Bronze (C34)	Thickness / Acetic Acid Salt Spray Test (AASS)
N20U7 N20U8 N20U9	20 µm	Natural (C0)	Thickness / Acetic Acid Salt Spray Test (AASS)
N20C7 N20C8 N20C9	20 µm	Dark Bronze (C34)	Thickness / Acetic Acid Salt Spray Test (AASS)

Results

Mass Loss Test

Class 15 µm

Sealing System	Color	Coating thickness [µm]	Result 1 [mg/dm^2]	Result 2 [mg/dm^2]	Result 3 [mg/dm^2]	Average [mg/dm^2]	Rating
S STANDARD PROCESS	*C0*						
	C34						
N NEW PROCESS	*C0*						
	C34						

Class 20 µm

Sealing System	Color	Coating thickness [µm]	Result 1 [mg/dm^2]	Result 2 [mg/dm^2]	Result 3 [mg/dm^2]	Average [mg/dm^2]	Rating
S STANDARD PROCESS	*C0*						
	C34						
N NEW PROCESS	*C0*						
	C34						

Dye Spot Test

Class 15 µm

Sealing System	Color	Coating thickness [µm]	Sample 1	Sample 2	Sample 3	Rating
S STANDARD PROCESS	*C0*					
N NEW PROCESS	*C0*					

Class 20 µm

Sealing System	Color	Coating thickness [µm]	Sample 1	Sample 2	Sample 3	Rating
S STANDARD PROCESS	*C0*					
N NEW PROCESS	*C0*					

Admittance Test

Class 15 µm

Sealing System	Color	Coating thickness [µm]	Sample 1 [µS]	Sample 2 [µS]	Sample 3 [µS]	Average [µS]	Limit [µS]	Rating
S STANDARD PROCESS	*C0*						20	
	C34							
N NEW PROCESS	*C0*						20	
	C34							

Class 20 µm

Sealing System	Color	Coating thickness [µm]	Sample 1 [µS]	Sample 2 [µS]	Sample 3 [µS]	Average [µS]	Limit [µS]	Rating
S STANDARD PROCESS	*C0*						20	
	C34							
N NEW PROCESS	*C0*						20	
	C34							

Acetic Acid Salt Spray test

Date of last corrosivity check: *XX/XX/XXXX*

R_P values determined from the percentage of the inspection areas showing pitting corrosion (if carried out).

Class 15 µm

Sealing System	Color	Coating thickness [µm]	Sample 1	Sample 2	Sample 3
S STANDARD PROCESS	*C0*				
	C34				
N NEW PROCESS	*C0*				
	C34				

Class 20 µm

Sealing System	Color	Coating thickness [µm]	Sample 1	Sample 2	Sample 3
S STANDARD PROCESS	*C0*				
	C34				
N NEW PROCESS	*C0*				
	C34				

Results of visual examination (if carried out):

……..

……..

……..

Surface Abrasion Resistance test

Class 15 µm

Sealing System	Color	Coating thickness [µm]	Sample 1	Sample 2	Sample 3	Rating
S STANDARD PROCESS	*C0*					
	C34					
N NEW PROCESS	*C0*					
	C34					

Class 20 µm

Sealing System	Color	Coating thickness [µm]	Sample 1	Sample 2	Sample 3	Rating
S STANDARD PROCESS	*C0*					
	C34					
N NEW PROCESS	*C0*					
	C34					

Conclusion

The process or product of the current application has been tested as prescribed in the QUALANOD Specifications clause 10 and General Regulations VI.

11/30/2020

_____	_____
Signature Testing Institute	Signature Testing Institute

Image documentation

Image 1 – Reference system (S) 15 µm C0 after the AASS test
Image 2 – Reference system (S) 15 µm C34 after the AASS test
Image 3 – Reference system (S) 20 µm C0 after the AASS test
Image 4 – Reference system (S) 20 µm C34 after the AASS test
Image 5 – New product (N) 15 µm C0 after the AASS test
Image 6 – New product (N) 15 µm C34 after the AASS test
Image 7 – New product (N) 20 µm C0 after the AASS test
Image 8 – New product (N) 20 µm C34 after the AASS test