



# ANODISER

## Master Inspection Report

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According to the requirements of Appendix A15 of the QUALICOAT Specifications

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Report no. \_\_\_\_\_

**COMPANY**

Name			
Plant Address			
Phone			
Responsible person(s) (contact)			
Licence number		(leave blank for GR1)	Number of anodising lines

**ANODISING LINE INSPECTION**

<b>DATE OF INSPECTION</b> (use dropdown calendar)	<b>DESIGNATION OF THE ANODISING LINE</b>		
<b>INSPECTION NO.</b>	Granting		
	Renewal		
<b>TYPE OF INSPECTION</b>	Repetition		
<b>DATE OF LAST INSPECTION</b> (use dropdown calendar)	Has anything changed in the plant since the last inspection?	YES NO	If YES what?
Testing laboratory			
Name of inspector	1:		2:
Is the inspection unannounced?	YES NO	If NO why?	
Is an inspection possible?	YES NO	If NO why?	
Remarks			



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1. PRE-REQUIREMENTS OF THE ANODISER

The inspector shall verify if the anodiser has requirements for becoming a licensed anodiser.

1.1 QUALITY MANAGEMENT SYSTEM

YES NO

Does the anodising plant has a QUALANOD licence or is accredited by an accreditation body for a Quality Management System?

If yes, please specify:

Qualanod licence

Other Management System

Licence number

Details

(please attached copy of the accreditation certificate)

Remarks

1.2 COATER’S REQUIREMENTS

YES NO

Does the coater(s) have a QUALICOAT license with SEASIDE (PRE-OX) endorsement?

Coater A

Coater B

Coater C

Licence number

Remarks

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## 2. AGREEMENT WITH THE COATER

### 2.1 GENERAL AGREEMENT WITH THE COATERS

The inspector shall verify if the anodiser has shared with the coater(s) the technical description of the process and that it was approved and signed by the anodiser and the coater.

YES NO

Is there an agreement between the anodiser and the licenced coater?

Are the following information included in the agreement or in the order checklist?

YES NO

Complete description of all the process/parameters to be used

Detailed description of rinsing conditions (30 µS) including information about the usage and the type of hot sealing or approved passivation and related parameters, values, and limits

Number of test panels which are produced in the same lot together with the material

Alloy

Etching requirements of cast material

Location of jigging marks

Remarks

### 2.2 CHECKLIST FOR OUTSOURCED ANODISING WORK

The inspector checks the documents related to some productions for verifying if all the details are included.

Date of order is given

Unique reference

(e.g. order no. / job card no. / process no. for reference)

Type of product

Profiles

Sheets

Others

Bill of material includes

Numbers

YES NO

Lengths

YES NO

Perimeter

YES NO

m<sup>2</sup>

YES NO

Drawings

YES NO

If NO, please specify

Alloy

Requested treatment

PRE-OX

Declared layer thickness

4-10µm

Remarks

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	From Extruder / Trader	From Powder Coater	Complete delivery	Partial delivery
Delivery of treated parts				
Entry control by anodiser	YES NO	Visual check	OK NOT OK	
Remarks				
Exit control by anodiser	YES NO	Visual check	OK NOT OK	
Remarks				
Extra samples provided	YES NO	Are the extra samples declared to be made of the same material as the delivery?		YES NO
If not please specify				
Date and time of Anodising production (A)			Date and time of Sample production	

## 2.3 DELIVERY APPOINTMENTS BETWEEN SENDER AND RECIPIENT

(storage period in accordance with Chapter 3, section 3.4 of the QUALICOAT Specifications)

Date of material receipt		(effective goods receipt date)
Material delivery (latest)		(date of completion of the final delivery)
Desired pickup date		(originally requested date of pickup)
Remarks		



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## 2.4 FEEDBACK FROM THE COATER

Are the following information communicated by the coater to the anodiser for each delivery? YES NO

Name and licence number of the coater

Date and time of anodising (A)

Date and time of coating (B)

Order number

Rinsing water conductivity, if carried out (max. 30 µS)

P-No. and colour

Results of the wet adhesion test

## 3. STORAGE CONDITIONS BEFORE TREATMENT

### 3.1 PARTS TO BE TREATED

Are parts to be treated stored in accordance with Chapter 3, section 3.1.1 of the QUALICOAT Specifications? YES NO

Remarks

### 3.2 CHEMICAL PRODUCTS

Do the storage conditions comply with the chemical manufacturer's requirements? YES NO

Remarks

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## 4. INSPECTION OF LABORATORY AND APPARATUS

### 4.1 LABORATORY

Appearance correct      YES    NO

Remarks

### 4.2 APPARATUS

#### Instruments for measuring coating thickness (ISO 2360)

Verify the calibration of the instrument using two suitable standards according to the thickness to be measured

	Instrument A		Instrument B	
	MAKE		MAKE	
	MODEL		MODEL	
	No.		No.	
Deviation from the standard value	REQUIRED	MEASURED	REQUIRED	MEASURED
	- Set-up I: 0 µm range ± 1			
	- Set-up II 10 µm range ± 1			
	- Set-up III 20 µm range ± 1.5			
	- Function			

Calibration standards/ foils available	YES    NO	Remarks	
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Data sheet with identifi- cation no. and calibration records available	YES    NO	Remarks	
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### 4.3 Conductivity Meter

Make		Model		No	
Reference test solution		$\mu\text{S/cm}$	Temperature		$^{\circ}\text{C}$
Measured		$\mu\text{S/cm}$	Temperature		$^{\circ}\text{C}$
Function ( $\leq 2 \mu\text{S/cm}$ )		Calibration solution $\leq 100 \mu\text{S/cm}$ available	YES	NO	
Data sheet with identification no. and calibration records available	YES	NO			
Remarks					

### 4.4 pH Meter

Make		Model		No	
Test of the electrodes with two standard test solutions	Solution 1		pH	Measured	
	Solution 2		pH	Measured	
Function ( $\pm 0.1$ )					
Remarks					





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## 5 PROCESS INSPECTION

### 5.1 TYPE OF PRETREATMENT

Anodic pretreatment

Anodic pretreatment +  
Chemical pretreatment (Chrome VI-free)

QUALICOAT approval No.  
(e.g. AP-003 / AP-132)

Anodic pretreatment +  
Chromate pretreatment

Remarks

### 5.2 DEGREASING - ETCHING - DESMUTTING

		DEGREASING	ETCHING	DESMUTTING*
SUPPLIER				
PRODUCT				
Temperature (°C)	required			
	measured			
Concentration	required			
	measured			
Immersion/spray time (min)	required			
	measured			

\* mandatory for Alkaline  
etching

Total etching  
rate g/m²

(requested ≥ 2g/m²)

Remarks

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### 5.3 ANODISING

	RECOMMENDED	MEASURED
Temperature of anodising bath	20 - 30 °C	
Acid concentration	180 – 220 g/l	
Aluminium content	5 – 15 g/l	

Remarks

### 5.4 CONVERSION (if made)\*

	REQUIRED		MEASURED	
Temperature		°C		°C
Concentration / extinction				
Conductivity		µS/cm		µS/cm
Immersion/spray time				
pH value				

\*only rinse pretreatment allowed

Remarks

### 5.5 FINAL RINSING

	REQUIRED*	MEASURED
Conductivity of the final rinsing	30 µS/cm at 20°C	
Conductivity of dripping water	30 µS/cm at 20°C	

\*Not required in case of a further rinsing with a conductivity of max. 30 µS/cm at 20°C is carried out at the coater's plant.

Remarks



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6 INSPECTION OF FINISHED PRODUCTS

6.1 INSPECTION OF ANODISED PARTS (which have been released by the anodiser)

Type of production	Sections	Sheets	Small parts	Others
Remarks				

6.2 THICKNESS OF ANODIC FILM (anodic coating without powdering and surface flaws)

ORDER NO.		LOT SIZE	
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Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

ORDER NO.		LOT SIZE	
-----------	--	----------	--

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

ORDER NO.		LOT SIZE	
-----------	--	----------	--

Section	1	2	3	4	5	6	7	8	9	10
Thickness in [µm]										

Remarks	
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7 IN-HOUSE CONTROL

CATEGORY OF TEST		CONFORMITY	
		Minimum frequency required	Recorded
TESTING OF FINISHED PRODUCTS	APPEARANCE (anodic coating without powdering and surface flaws)	Every flight bar	
	COATING THICKNESS (ISO 2360)	Every flight bar	
PROCESS TESTING	DEGREASING/ETCHING AND DESMUTTING TEMPERATURE	Every 8 hours	
	DEGREASING/ETCHING AND DESMUTTING CONCENTRATION	Once per day	
	WEIGHT OF ALUMINIUM REMOVED (etching degree)	Once per day	
	TEMPERATURE OF ANODISING BATH	Every 8 hours	
	ACID CONCENTRATION OF ANODISING BATH	Once per day	
	ALUMINIUM CONCENTRATION OF ANODISING BATH	Once per day	
	CONVERSION PARAMETERS	Every 8 hours	
	CONDUCTIVITY OF THE FINAL RINSE	Minimum once per day	
	CONDUCTIVITY OF THE DRIPPING WATER	Minimum once per day	

RECORDS AND REGISTERS

YES NO  
up to date

PRODUCTION CONTROL REGISTER

YES NO  
up to date

STANDARDS OR OPERATING INSTRUCTIONS BASED ON THE STANDARDS

YES NO  
are available for all tests

Remarks



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8 OTHERS

Specifications

Is the latest edition of the QUALICOAT Specifications (including current Update Sheets) available to the person(s) responsible?

YES NO

Use of the label (see Appendix A15, section 3.6 of the QUALICOAT Specifications)

YES NO

Does the use of the logo comply with the regulations for use of the QUALICOAT quality label?

If Not, why?

INSPECTION BODY

DATE

INSPECTOR'S SIGNATURE

DATE

LABORATORY'S SIGNATURE

GENERAL LICENSEE

DATE

RESULT RECOMMENDATION TO QUALICOAT\*

SATISFACTORY

NOT SATISFACTORY

REMARKS GL

\* The final assessment is made by QUALICOAT



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SUMMARIZING SHEET

Form to be completed at the end of an inspection

ANODISER

LICENCE NUMBER

DATE OF INSPECTION

ANODISING LINE

NAME OF INSPECTOR

INSPECTION NO.

Granting

Renewal

Repetition

RESOLUTION OF PREVIOUS ISSUES AND NONCONFORMITIES:

1

2

3

4

RESULTS

SUMMARY OF TESTS AND INSPECTION	ISSUES AND/OR NONCONFORMITIES	ANODISER'S REMARKS
AGREEMENTS WITH THE COATER + STORAGE CONDITIONS		
INSPECTION OF LABORATORY EQUIPMENT		



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SUMMARY OF TESTS AND INSPECTION	ISSUES AND/OR NONCONFORMITIES	ANODISER'S REMARKS
INSPECTION OF PRODUCTION PROCESS + INSPECTION OF CONVERSION PROCESS (if made)		
INSPECTION OF FINISHED PRODUCTS + STORAGE CONDITIONS OF FINISHED PRODUCTS		
REVIEW OF IN-HOUSE CONTROL AND REGISTERS		
OTHERS (CLAIMS REGISTER, USE OF THE LABEL, ETC.)		

INSPECTOR'S SIGNATURE

PLANT MANAGER'S SIGNATURE



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**ADDITIONAL FILES**  
**UPLOAD 1/4**

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**ADDITIONAL FILES**  
**UPLOAD 2/4**

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**ADDITIONAL FILES**  
**UPLOAD 3/4**

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**ADDITIONAL FILES**  
**UPLOAD 4/4**

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